

Appendix O

Safety-Related Construction Inspection Plans

Appendix O

Safety-Related Construction Inspection Plans

System	Drawing	Description	Plan Number	Rev.	Status	Comments
N/A	A-5	PHASE 1 INSTALLATION	N/A	N/A	N/A	NO ACTION REQUIRED PER SURVEILLANCE 1 178
N/A	A-9	PHASE 2 INSTALLATION	N/A	N/A	N/A	NO ACTION REQUIRED PER SURVEILLANCE 1 178
CAS	S-8	CAS FRAMES/SUPPORTS	21052-S-08	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1 178
	s-10	LIGHT/ALARM POLE SUPPORTS				
	S-11	CAS LIGHT/HORN SUPPORTS				
RCS	P-11	RCS (DUST SUPP) BULKHEAD FITTINGS	2 1052-M-04	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1 178
	FP-8	RCS (FIRE PROT) BULKHEAD FITTINGS				
	E-22	RCS ELECT. PENET SEAL WELDS				
	LSS-6	RCS ELECT. PENET SEAL WELDS				
FFS	FP-10	FLOOR STRUCTURE (FIRE PROT) PENETRATIONS	21052-S-01	1	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1 178
H&V	HV-2	HVAC FLOW DIAGRAM	21052-V-02	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1 178
	HV-6	HVAC VENTILATION FLOOR PLAN				
	HV-7	HVAC DETAILS & SECTIONS				
	HV-8	HVAC DETAILS & SECTIONS				
	HV-10	HVAC DETAILS & SECTIONS				

System	Drawing	Description	Plan Number	Rev.	Status	Comments
CAS	IN-13	CAS CONDUIT AND CABLE	21052-E-01	1	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178
	IN-16	CAS CABINET & WIRE SCHEDULE				
	IN-18	CAS WIRING				
	IN-19	CAS CONTROL ENCLOSURE ASSEMBLY				
	IN-20	CAS DETAILS				
FFS	s-2	HANDRAIL DROP-INS (WELDING TO FLOOR)	21052-S-10	1	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
PGS	APP. A	PACKAGING GLOVEBOX SYSTEM INSTALLATION	21052-M-03	1	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
	1522001					
	522004					
EXCAVATOR	APP. C	BACKHOE INSTALLATION	21052-S-07	1	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
	519933					
WES	E-22	WES LINER PENETRATIONS	21052-M-05	1	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
FFS		FACILITY STRUCTURES	21052-M-01	3	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178 TRANSMITTAL 03-103A
STACK		STACK INSTALLATION	21052-M-02	1	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
N/A		MOCKUP	21052-MOCKUP-01	1	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178
VARIOUS		RECEIPT INSPECTION (WELD ROD UPGRADE)	21052-R-01	1	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178 TRANSMITTAL 02-0038A

System	Drawing:	Description	Plan Number	Rev.	Status	Comments
VARIOUS		RECEIPT INSPECTION (STEEL EST/WARBONNET/3D/ATLAS)	21052-R-02	3	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178 TRANSMITTAL 03-108A
CAS		RECEIPT INSPECTION (CAS CONTROL ENCLOSURE ONLY)	21052-R-03	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
CAS		CRITICALITY DETECTOR CLUSTER FRAME-SHOP	21052-S-02	0	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178 TRANSMITTAL 03-011A
CAS		CRITICALITY CONSOLE HOUSING FRAME-SHOP	21052-S-03	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
CAS		LIGHT/ALARM POLE SUPPORTS-SHOP	21052-S-04	1	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178 TRANSMITTAL 03-013A
CAS		CRITICALITY ALARM SUPPORTS- SHOP	21052-S-05	0	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178 TRANSMITTAL 03-014A
FFS		DCN FS- 19	21052-S-06	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
H&V		SST DUCTWORK-SHOP	21052-V-01	0	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178 TRANSMITTAL 03-102A
RCS		ICR-065 RCS PANEL REPAIR	21052-M-07	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
RCS		ICR-062 RCS PANEL REPAIR	21052-M-06	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
WES		ICR-041 WES SNOW SHIELDS	21052-M-08	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178

System	Drawing	Description	Plan Number	Rev.	Status	Comments
FFS		DCN FP-17	21052-S-09	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
FFS		FCR-13233-90 SST PLATE	21052-M-10	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
PGS		GLOVEBOX TESTING	21052-M-11	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
CAS		FCR-13233-118 and 13233-96 MISC. ELECTRICAL ITEMS	21052-R-04	0	CLOSED	NOT REVIEWED DURING SURVEILLANCE 1178-NO ACTION TAKEN
WES		WES ARCHITECTURAL FABRIC	21052-R-05	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
FFS		FCR-13233-76 STUD WELDS	21052-S-11	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
PGS		PGS #2 NCR-30108 REWORK	21052-S-12	0	CLOSED	NOT REVIEWED DURING SURVEILLANCE 1178-NO ACTION TAKEN
RCS		RCS PENETRATIONS AND TEK SCREWS INSTALLATION	21052-M-18	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
FFS		DCN FS-28 SEAL WELDS	21052-M-17	0	CLOSED	CORRECTIONS REQUIRED PER SURVEILLANCE 1178
RCS		MISC. RCS PENETRATIONS FCR-13233-190 AND TEK SCREWS	21052-R-07	1	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
RCS		RCS LEAK TESTING	21052-M-12	1	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
H&V		STAINLESS STEEL DUCT SPOOL PIECE PER DCN FS-84	21052-V-03	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
STACK		STACK BOLT INSPECTION	21052-M-19	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178

System	Drawing	Description	Plan Number	Rev.	Status	Comments
VARIOUS		SAFETY SIGNIFICANT DIMENSIONS	21052-M-16	0	CLOSED	NOT REVIEWED DURING SURVEILLANCE 1178-NO ACTION TAKEN
FFS		TOOL TABLE WELDS	21052-S-15	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
RCS		DCN FP-47 CGI AND SEAL WELDS	21052-M-13	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
FFS		DCN FP-52 BOLTS	21052-M-14	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
RCS		FCR 13233-137 GASKET REPAIR	21052-M-15	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
EXCAVATOR		FCN-13233-153 KEEPER CLIPS	21052-S-13	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
CAS		MISC. CAS ITEMS	21052-R-06	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
RCS		FCR-13233-147 RCS BASE ANGLE	21052-S-14	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
RCS		ICR-066 PATCHES	21052-M-09	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
EXCAVATOR		SWING STOPS	21052-S-16	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178
WES		NCR-31148 FRENCH CAN'S	21052-M-20	0	CLOSED	NO ACTION REQUIRED PER SURVEILLANCE 1178

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CONSTRUCTION INSPECTION PLANNING PACKAGE

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Final Q&E Review:

Date: 4-11-03

WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: STEVE DAVIES PER TOM HIPP	Q E Ron Staymates 10/28/02 <i>RS</i>
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (CAS/POLE SUPPORT INSTALLATION <i>EMAIL</i>)			Release Date: 1-10-03
ACTIVITIES) Floor Structure is safety significant (Q2)/ WES is low safety consequence (Q3)/ RCS is safety significant (Q2) <i>DATED 7/10/03</i>			

P No. 21052-S-08		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.0	General	TDD 414	Verify 100%	Verify that Receipt Inspection has been performed per 21052-R-02 on the items being inspected.	3-13-03 CEK
2.0	Structural Steel and Misc. Metals	5100 and Drawing S-8, S-10 and S-11	Verify Random Checklist 414.A15	Verify that the structural steel is erected / installed per the approved drawings. Record IR number: 021052-S-	3-13-03 CEK
2.1	Structural Steel and Misc. Metal	5100 and Drawing S-10	Verify Random	Verify that Grade 8 bolted connections have been installed and torqued per manufacturers recommendations. Record IR number: 021052-S-100	3-13-03 CEK
3.0	Structural Steel and Misc. Metal	5100 and Drawing S-10	Verify 100%	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: 021052-S-100	3-13-03 CEK
3.1	Structural Steel and Misc Metal	5100 and Drawing S-10	Verify 100%	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number: 021052-S-100	3-13-03 CEK
3.2	Structural Steel and Misc. Metal	5100 and Drawing S-10	Verify 100%	Verify that the welding process is being performed in accordance with the parameters defined in the WPS, including the following: a) base metal preparation 3-13-03 CEK b) cleaning 3-13-03 CEK c) preheat temperature 3-13-03 CEK d) interpass temperature 3-13-03 CEK e) temporary welds 3-13-03 CEK f) backing strips/runoff tabs N/A g) joint preparation N/A Record IR number: 021052-S-	3-13-03 CEK

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IP No. 21052-S-08		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
3.3	Structural Steel and Misc. Metal	5100 and Drawing S-10	Verify 100%	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 021052-S-100	3-13-03 CEK
3.4	Structural Steel and Misc. Metal	5100 and Drawing S-10	TPR-4981, Appendix D Visual 100% Static Loaded HOLD POINT	Visually inspect welds per AWS D1.1. Record IR Number: 021052-S-100	3-13-03 CEK
4.0	Structural Steel and Misc. Metal	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: 021052-S-100	3-13-03 CEK
5.0	General	MCP-9436 App. A, B & C	Verify Random Checklist 414.A33	Verify that materials / items are segregated based on quality level, with no commingling of quality levels. Record IR number: 021052-S-100	3-13-03 CEK
5.1	General	MCP-9436 App. A, B & C And STD-7006	Verify Random Checklist 414.A33	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: 021052-S-100	3-13-03 CEK
6.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	3-13-03 CEK

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE PE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION/ ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & T SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.

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- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".
- 15) CHECKUAT 414.A15 IS BEING PILOTTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE.

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CONSTRUCTION INSPECTION PLANNING PACKAGE

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Final QE Review:

Date: 4/2/03

WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: KAREN SHARP SHREPER	QE: Ron Staymates 11/11/02
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (RCS PENETRATION ACTIVITIES) ENHANCEMENT Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2) 12/20/02			Release Date: 12-20-02

IP No. 21052-M-04		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS.	
1.0	General	IPR-6416	Verify 100%	Verify that Receipt Inspection has been performed per 21052-R-02 on the items being inspected. See IP 21052-R-02	4-16-03 CEK
1.0	RCS Seal Welds	Drawing E-22, LSS-6, FCR 13233-61 and DCN-FP-18	Verify 100%	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: 02105-M-11	4-16-03 CEK
1.1	RCS Seal Welds	Drawing E-22, LSS-6, FCR 13233-61 and DCN-FP-18	Verify 100%	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number: 02105-M-11	4-16-03 CEK
1.2	RCS Seal Welds	Drawing E-22, LSS-6, FCR 13233-61 and DCN-FP-18	Verify 100%	Verify that the welding process is being performed in accordance with the parameters defined in the WPS, including the following: a) base metal preparation CEK 4-16-03 b) cleaning CEK 4-16-03 c) preheat temperature N/A d) interpass temperature N/A e) temporary welds N/A f) backing stripe/runoff tabs N/A g) joint preparation CEK 4-16-03 Record IR number: 02105-M-11	4-16-03 CEK

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CONSTRUCTION INSPECTION PLANNING PACKAGE

DATE: 10/11/03
BY: [Signature]

IP No. 21052-M-04		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.4	RCS Seal Welds	Drawing E-22, LSS-8, FCR 13233-61 and DCN -FP-18	Verify 100%	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 021052-M-111	4-16-03 CEK
1.5	RCS Seal Welds	Drawing E-22, LSS-8, FCR 13233-61 and DCN -FP-18	TPR-4981 Visual 100% Static Loaded HOLD POINT	Visually inspect welds per AWS D1.6. (copy attached) NOTE: Weld size is not applicable for this inspection, only the weld quality is critical. Record IR Number: 021052-M-111	4-16-03 CEK
2.0	RCS Bulkhead Fittings	Drawing P-11, HV-8 and FP-8 FCR-13233-22	Verify Random	Verify that the bulkhead fittings have been installed per the approved drawings. Record IR number: 021052-M-111	4-16-03 CEK
3.0	RCS FP Penetration Transfer Vestibule Ceiling	FCR 13233-71	Verify Random	Verify that the penetration installation is in accordance the FCR, including opening size, silicone sealant and use of the Grinnell Figure 395 ceiling plate. Record IR number: 021052-M-111	4-16-03 CEK
3.1	RCS FP Penetration Personnel Access Area Wall	FCR 13233-71	Verify Random	Verify that the penetration installation is in accordance the FCR, including opening size, silicone sealant and use of the Grinnell Figure 395 ceiling plate. Record IR number: 021052-M-111	4-16-03 CEK
3.2	RCS FP Penetration Personnel Monitoring Area Wall	FCR 13233-71	Verify Random	Verify that the penetration installation is in accordance the FCR, including opening size, silicone sealant and use of the Grinnell Figure 395 ceiling plate. Record IR number: 021052-M-111	4-16-03 CEK
4.0	Structural Steel and Misc. Metal	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: 021052-M-111	4-16-03 CEK
5.0	General	MCP-9436 App. A, B & C	Verify Random Checklist 414.A33	Verify that materials / items are segregated based on quality level, with no commingling of quality levels. Record IR number: 021052-M-111	4-16-03 CEK
5.1	General	MCP-9438 App. A, B & C And STD-7006	Verify Random Checklist 414.A33	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: 021052-M-111	4-16-03 CEK
6.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure. 021052-M-111	4-16-03 CEK

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INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM, THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".
- 15) CHECKLIST 414.A15 IS BEING PILOTTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE.

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Final QE Review:

Date: 4-9-03

WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: <i>LOUIS GUINEN PERMANENT</i>	QE: Ron Staymates 12/04/02
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (Fire Protection Pipe Sleeves per FCR 13233-48)			Release Date: 12-20-02
Floor Structure is safety significant (Q2) / RCS is safety significant (Q2)			

IP No. 21052-S-01		Rev. 1	Rev. 1. Incorporated FCR 13233-48		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL WELDING PROCESSES TO THE FLOOR STRUCTURE SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.46 OR FORM 432.43 OR THE DRAWINGS.	N/A
1.0	Structural Welding Per Drawing 522704 & 705	5060, pg 3 line 25 thru 36	Verify 100%	Verify that the welders are qualified to perform the welding process and have a current qualification and has been approved in the vendor data system NOTE: Receipt Inspection per Inspection Plan 21052-R-01 is required for the weld rod. Record IR number: 021052-P-041	2-5-03 CER
1.1	Structural Welding Per Drawing 522704 & 705	5060, pg 4 line 30 thru 37	Verify Random	Verify that the filler metal is the correct type per the WPS and that it is traceable to a CMTR and has been approved in the vendor data system. Record IR number: 021052-P-041	2-5-03 CER
1.2	Structural Welding Per Drawing 522704 & 705	5060, pg 5 line 11 thru 44 & pg 6 line 1 thru 35	Verify Random	Verify that the welding process is being performed in accordance with the parameters defined in the approved vendor data WPS, including the following: a) base metal preparation 2-5-03 CER b) cleaning 2-5-03 CER c) preheat temperature 2-5-03 CER d) interpass temperature 2-5-03 CER e) temporary welds 2-5-03 CER CER NA f) backing strips/runoff tabs NA g) joint preparation 2-5-03 CER Record IR number: 021052-P-041	2-5-03 CER
1.3	Structural Welding Per Drawing 522704 & 705	5060, pg 6 line 37 thru 42 & pg 7 line 1 thru 12	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: 021052-P-041	2-5-03 CER

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CONSTRUCTION INSPECTION ANNING PACKAGE

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IP No. 21052-S-01		Rev. 1	Rev. 1. Incorporated FCR 13233-48		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.4	Structural Welding Per Drawing 522704 & 705	5060, pg 7 line 14 thru 17	Verify Random	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 021052-P-041	2-3-03 CEL
1.5	Structural Welding Per Drawing 522704 & 705	5060, pg. 7 line 34 thru 38	TPR-4981, Appendix D Visual 100% Static Loaded HOLD POINT	Visually inspect pipe sleeve welds per AWS D1.1 Record IR Number: 021052-P-041	2-3-03 CEL
2.0	General	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: 021052-P-041	2-3-03 CEL
3.0	General	MCP-9436 App. A, B & C	Verify Random Checklist 414.A33	Verify that materials / items are segregated based on quality level, with no commingling of quality levels. Record IR number: 021052-P-041	2-3-03 CEL
4.0	General	MCP-9436 App. A, B & C And STD-7006	Verify Random Checklist 414.A33	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: 021052-P-041	2-3-03 CEL
5.00	General	MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure. 021052-P-041	2-3-03 CEL

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.05, QUALITY INSPECTION REPORT AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 VISUAL INSPECTION REPORT AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION/ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & T SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.

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- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR NIA'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / WUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A GENERAL INSPECTOR.
- 15) CHECKLIST 414.A15 IS BEING PILOTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF M E Q E AND THE RE.

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CONSTRUCTION INSPECTION PLANNING PACKAGE

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Final QE Review: _____ Date: _____

WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: <i>LOUIS GUILLEN FOR EMAN</i>	QE: Ron Staymates 11/11/02 <i>RS</i>
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (HVAC INSTALLATION ACTIVITIES)			
Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2) <i>12/10/02</i>			Release Date: <i>12-20-03</i>

IP No. 21052-V-02		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS.	
1.0	General	TPR-6416	Verify 100%	Verify that receipt inspection has been performed per inspection plan 21052-R-02 for the HVAC Ductwork upon arrival at site. Record IR number:	
1.0	Stainless Steel Ductwork FIELD WELDS ONLY	15014	Verify Random	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number:	
1.1	Stainless Steel Ductwork FIELD WELDS ONLY	15014	Verify Random	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number:	
1.2	Stainless Steel Ductwork FIELD WELDS ONLY	15014	Verify Random	Verify that the welding process is being performed in accordance with the parameters defined in the WPS, including the following: a) base metal preparation b) cleaning c) preheat temperature d) interpass temperature e) temporary welds f) backing strips/runoff tabs g) joint preparation Record IR number:	

NO STAINLESS STEEL DUCT WELDING PERFORMED IN THE FIELD. *By Staymates 4/8/03*
CER 4-8-03

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CONSTRUCTION INSPECTION PLANNING PACKAGE

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IP No. 21052-Y-02		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.3	Stainless Steel Ductwork FIELD WELDS ONLY	15014	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number:	
1.4	Stainless Steel Ductwork FIELD WELDS ONLY	15014	Verify Random	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number:	
1.5	Stainless Steel Ductwork FIELD WELDS ONLY	15014	TPR-4981 Visual 100% Static Loaded HOLD POINT	Visually inspect welds per AWS D9.1.(copy attached) Record IR Number:	
2.0	Stainless Steel Ductwork FIELD WELDS ONLY	15014	TPR-4975, Appendix C Visual 100%	Liquid Penetrant examine the final pass on all welds, using water washable removable color contrast penetrant. Acceptance criteria will be defined on a design change document (DCN / FCR). Record IR number:	
3.0	Stainless Steel Ductwork	15014 and Drawings HV-6, 7, 8, 10 See HV-3, 4, 5 & 9 for general location information	Verify Random Checklist 414.A30 Item 1.1, 2.1, 2.3, 2.4, 2.5, 2.6, 2.7, 2.8, 2.9, 3.3, 3.5, 3.8, 3.9 and 4.1 only	Verify that the ductwork is erected per the approved shop drawings. Record IR number:	
3.1	Stainless Steel Ductwork	15014 and Drawings HV-7	Verify Random Checklist 414.A30 Item 1.1, 2.1, 2.3, 2.4, 2.5, 2.6, 2.7, 2.8, 2.9, 3.3, 3.5, 3.8, 3.9 and 4.1 only	Verify that the HEPA Filters, Moisture Separators and Pre-Filters are installed per drawing HV-7 Record IR number:	

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IP No. 21052-V-02		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
3.2	Stainless Steel Ductwork	15014 and Drawings HV-7	Verify Random Checklist 414.A30 Item 1.1, 2.1, 2.3, 2.4, 2.5, 2.6, 2.7, 2.8, 2.9, 3.3, 3.5, 3.8, 3.9 and 4.1 only	Verify that the motorized damper (HV-DMP-52) is installed per drawing HV-7. Record IR number:	
4.0	Stainless Steel Ductwork	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number:	
5.0	General	MCP-9436 App. A, B & C	Verify Random Checklist 414.A33	Verify that materials / items are segregated based on quality level, with no commingling of quality levels. Record IR number:	
5.1	General	MCP-9436 App. A, B & C And STD-7006	Verify Random Checklist 414.A33	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number:	
6.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION WILL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON M R M 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (M R M 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION W E DATES HAVE BEEN RECORDED.
- 8) NCA / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.

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- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".
- 15) CHECKUST 414.A15 IS BEING PILOTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE,

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Final QE Review:

Date:

WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: <i>STEVE DAVIES FOR EMAIL</i>	QE: Ron Staymates 12/20/02 <i>RS</i>
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (HANDRAIL DROP-IN INSTALLATION)			1/10/03
Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2)			Release Date: 1/10/03

P No. 21052-S-10		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS.	
1.0	Structural Steel and Misc. Metal	5100 and Drawing S-2	Verify 100%	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: <i>021052-S-092</i>	<i>2-26-03</i> <i>CEK</i>
1.1	Structural Steel and Misc. Metal	5100 and Drawing S-2	Verify 100%	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number: <i>021052-S-092</i>	<i>2-26-03</i> <i>CEK</i>
1.2	Structural Steel and Misc. Metal	5100 and Drawing S-2	Verify 100%	Verify that the welding process is being performed in accordance with the parameters defined in the WPS, including the following: a) base metal preparation <i>2-26-03 CEK</i> b) cleaning <i>CEK 2-26-03</i> c) preheat temperature <i>CEK 2-26-03</i> d) interpass temperature <i>N-A</i> e) temporary welds <i>N-A</i> f) backing strips/runoff tabs <i>N-A</i> g) joint preparation <i>CEK 2-26-03</i> Record IR number: <i>021052-S-092</i>	<i>2-26-03</i> <i>CEK</i>
1.3	Structural Steel and Misc. Metal	5100 and Drawing S-2	Verify 100%	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: <i>021052-S-092</i>	<i>2-26-03</i> <i>CEK</i>

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IP No. 21052-S-10		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.4	Structural Steel and Misc. Metal	5100 and Drawing S-2	TPR-4981, Appendix D Visual 100% Static Loaded HOLD POINT	Visually inspect welds per AWS D1.1 Record IR Number: 021052-S-092	2-26-03 CER
2.0	Structural Steel and Misc. Metal	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: 021052-S-092	2-26-03 CER
3.0	General	MCP-9436 App. A, B & C	Verify Random Checklist 414.A33	Verify that materials / items are segregated based on quality level, with no commingling of quality levels. Record IR number: 021052-S-092	2-26-03 CER
3.1	General	MCP-9436 App. A, B & C And STD-7008	Verify Random Checklist 414.A33	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: 021052-S-092	2-26-03 CER
4.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	2-26-03 CER

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORT 6 SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.06 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION [HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.] TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION/ ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.05 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION WE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.

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- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
- A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".

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Final QE Review: [Signature] Date: 4-7-03
SEE ATTACHED HQE LISTING

WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: <u>R. CARPENEDO PER EMAIL</u>	QE: Ron Staymates 11/11/02 <u>RS</u>
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (GLOVEBOX INSTALLATION ACTIVITIES) <u>1/303</u>			Release Date: <u>1/2/03</u>
Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2)			

P No. 21052-M-03		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OF FORM 452.43 OR THE DRAWINGS.	
1.0	Structural Welding Glovebox Number 1 Boot Attachment Welds	5060 and SPC-389 Appendix A, Drawing 519895	Verify Random	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: <u>021052-S-090</u>	<u>2-25-03</u> <u>CER</u>
1.1	Structural Welding Glovebox Number 1 Boot Attachment Weld 8	5060 and SPC-389 Appendix A, Drawing 519895	Verify Random	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number: <u>021052-S-090</u>	<u>2-25-03</u> <u>CER</u>
1.2	Structural Welding Glovebox Number 1 Boot Attachment Welds	5060 and SPC-389 Appendix A, Drawing 519895	verify Random	Verify that the welding is being performed in accordance with the parameters defined in the WPS including the wire: a) base metal preparation <u>CER 2-25-03</u> b) cleaning <u>CER 2-25-03</u> c) preheat temperature <u>N/A</u> d) interpass temperature <u>CER 2-25-03</u> e) temporary welds <u>CER 2-25-03</u> f) backing strips/runoff tabs <u>N/A</u> g) joint preparation <u>CER 2-25-03</u> Record IR number: <u>021052-S-090</u>	<u>2-25-03</u> <u>CER</u>

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CONSTRUCTION INSPECTION PLANNING PACKAGE

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No. 21052-M-03		Rev. 0			
No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.3	Structural Welding Glovebox Number 1 Boat Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 519895	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: 021052-S-090	2-25-03 CER
1.4	Structural Welding Glovebox Number 1 Boat Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 518895	Verify Random	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 021052-S-090	2-25-03 CER
1.5	Structural Welding Glovebox Number 1 Boat Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 519895	TPR-4981, Appendix O Visual 100% Static Loaded HOLD POINT	Visually inspect welds per AWS D1.1. Record IR Number: 021052-S-090	2-25-03 CER
2.0	Structural Welding Glovebox Number 2 Boat Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 519895	Verify Random	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: 021052-S-090	2-25-03 CER
2.1	Structural Welding Glovebox Number 2 Boat Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 514895	Verify Random	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number: 021052-S-090	2-25-03 CER

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No. 21052-M-03		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
2.2	Structural Welding Glovebox Number 2 Boot Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 519835	Verify Random	Verify that the welding process is being performed in accordance with the parameters defined in the WPS, including the following: h) base metal preparation CER 2-25-03 i) cleaning CER 2-25-03 j) preheat temperature N/A k) interpass temperature CER 2-25-03 l) temporary welds RECCO N/A m) backing strips/runoff tabs N/A n) joint preparation CER 2-25-03 Record IR number: 021052-S-090	2-25-03 CER
2.3	Structural Welding Glovebox Number 2 Boot Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 519895	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: 021052-S-090	2-25-03 CER
2.4	Structural Welding Glovebox Number 2 Boot Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 519895	Verify Random	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 021052-S-090	2-25-03 CER
2.5	Structural Welding Glovebox Number 2 Boot Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 519895	TPR-4981, Appendix D Visual 100% Static Loaded HOLD POINT	Visually inspect welds per AWS D1.1. Record IR Number: 021052-S-090	2-25-03 CER
3.0	Structural Welding Glovebox Number 3 Boot Attachment Welds	5060 and SPC- 389 Appendix A, Drawing 519895	Verify Random	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: 021052-S-090	2-25-03 2-25-03 CER

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IP No. 21052-M-03		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
3.1	Structural Welding Glovebox Number 3 Boot Attachment Welds	5060 and SPC-389 Appendix A, Drawing 519895	Verify Random	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number: 021052-S-090	2-25-03 CER
3.2	Structural Welding Glovebox Number 3 Boot Attachment Welds	5060 and SPC-389 Appendix A, Drawing 519895	Verify Random	Verify that the welding process is being performed in accordance with the parameters defined in the WPS, including the following: o) base metal preparation CER-2-25-03 p) cleaning CER 2-25-03 q) preheat temperature NA r) interpass temperature CER 2-25-03 s) temporary welds NA t) backing strips/runoff tabs NA u) joint preparation CER 2-25-03 Record IR number: 021052-S-090	2-25-03 CER
3.3	Structural Welding Glovebox Number 3 Boot Attachment Welds	5060 and SPC-389 Appendix A, Drawing 519895	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: 021052-S-090	2-25-03 CER
3.4	Structural Welding Glovebox Number 3 Boot Attachment Welds	5060 and SPC-389 Appendix A, Drawing 519895	Verify Random	Verify that an: strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1R2 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 021052-S-090	2-25-03 CER
3.5	Structural Welding Glovebox Number 3 Boot Attachment Welds	5060 and SPC-389 Appendix A, Drawing 519805	TPR-4981, Appendix D Visual 100% Static Loaded HOLD POINT	Visually inspect welds per AWS D1.1. Record IR Number: 021052-S-090	2-25-03 CER

CONSTRUCTION INSPECTION PLANNING PACKAGE

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BLACK - COPY

P No. 21052-M-03		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
4.0	Structural Steel and Misc. Metals Glovebox Number 1 Support Legs	5100, SPC-389 Appendix A and approved shop drawings Drawings A-1, A-5, A-8, P-8 AND P-10 for general location information	Verify Random Checklist 414.A15	Verify that the structural steel is erected per the erection plan, manufacturers recommendations and final approved shop drawings. Record IR number: 021052-S-090	2-25-03 CER
5.0	Structural Steel and Misc. Metal Glovebox Number 2 Support Legs	5100, SPC-389 Appendix A and approved shop drawings Drawings A-1, A-5, A-8, P-9 AND P-10 for general location information	Verify Random Checklist 414.A15	Verify that the structural steel is erected per the erection plan, manufacturers recommendations and final approved shop drawings. Record IR number: 021052-S-090	2-25-03 CER
6.0	Structural Steel and Misc. Metal Glovebox Number 3 Support Legs	5100, SPC-389 Appendix A and approved shop drawings Drawings A-1, A-5, A-8, P-8 AND P-10 for general location information	Verify Random Checklist 414.A15	Verify that the structural steel erected per the erection plan, manufacturers recommendations and final approved shop drawings. Record IR number: 021052-S-090	2-25-03 CER
7.0	Structural Steel and Misc. Metals Glovebox Number 1 Support Legs	5100, SPC-389 Appendix A and approved shop drawings	Verify Random	Verify that bolted connections have been installed per the manufacturers instructions. Record IR number: 021052-S-090	2-25-03 CER

CONSTRUCTION INSPECTION PLANNING PACKAGE

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P No. 21052-M-03		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
8.0	Structural Steel and Misc. Metals Glovebox Number 2 Support Lags	5100, SPC-389 Appendix A and approved shop drawings	Verify Random	Verify that bolted connections have been installed per the manufacturers instructions. Record IR number: 021052-S-090	2-25-03 CEH
9.0	Structural Steel and Misc. Metals Glovebox Number 3 Support Lags	5100, SPC-389 Appendix A and approved shop drawings	Verify Random	Verify that bolted connections have been installed per the manufacturers instructions. Record IR number: 021052-S-090	2-25-03 CEH
10.0	Glovebox Number 1	Approved Shop Drawings Drawings A-1, A-5, A-8, P-9 AND P-10 for general location information	Verify Random Checklist 414.A29, item 1.1, 2.1, 2.3, 2.7, 2.8, 3.1, 3.2, 5.1 or 5.2 only	Verify that the glovebox, including windows and gloveports is re-assembled in accordance with the manufacturers instructions. Record IR number: 021052-S-090	2-25-03 CEH
11.0	Glovebox Number 2	Approved Shop Drawings Drawings A-1, A-5, A-8, P-9 AND P-10 for general location information	Verify Random Checklist 414.A29, item 1.1, 2.1, 2.3, 2.7, 2.8, 3.1, 3.2, 5.1 or 5.2 only	Verify that the glovebox, including windows and gloveports is re-assembled in accordance with the manufacturers instructions. Record IR number: 021052-S-090	2-25-03 CEH
12.0	Glovebox Number 3	Approved Shop Drawings Drawings A-1, A-5, A-8, P-9 AND P-10 for general location information	Verify Random Checklist 414.A29, item 1.1, 2.1, 2.3, 2.7, 2.8, 3.1, 3.2, 5.1 or 5.2 only	Verify that the glovebox, including windows and gloveports is re-assembled in accordance with the manufacturers instructions. Record IR number: 021052-S-090	2-25-03 CEH
13.0	General	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: 021052-S-090	2-25-03 CEH
14.0	General	MCP-9436 App. A, B & C	Verify Random Checklist 414.A38	Verify that materials / items are segregated based on quality level, with no commingling of quality levels. Record IR number: 021052-S-090	2-25-03 CEH

CONSTRUCTION INSPECTION PLANNING PACKAGE

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IP No. 21052-M-03		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
14.1	General	MCP-9436 App. A, B & C And STD-7006	Verify Random Checklist 414.A33	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: 021052-S-090	2-28-03 CEP
15.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	2-28-03 CEP

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 VISUAL INSPECTION REPORT AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION/ ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUT / OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (IE. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".

CONSTRUCTION INSPECTION PLANNING PACKAGE

15) CHECKLIST 414.A15, A29 & A33 ARE BEING PILOTED IN THIS INSPECTION PLAN (REF. TPR-4921), AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE.

CONSTRUCTION INSPECTOR PLANNING PACKAGE

Final QE Review:

Date: 4-2-03

WC/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: BLAIR GROVER PER EMAIL	QE: Ron Staymates 11/11/02
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (BACKHOE INSTALLATION ACTIVITIES) 2/1/03			Release Date: 2-17-03
Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2)			

No. 21052-S-07		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Data
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS.	
1.0	Structural Welding FIELD WELDS ONLY	5060 and SPC-389 Appendix C, drawing 519933	Verify Random	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: 021052-S-104	4-2-03 CER
1.1	Structural Welding FIELD WELDS ONLY	5060 and SPC-389 Appendix C, drawing 519933	Verify Random	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number: 021052-S-104	4-2-03 CER
1.2	Structural Welding FIELD WELDS ONLY	5060 and SPC-389 Appendix C, drawing 519933	Verify Random	Verify that the welding process is being performed in accordance with the parameters defined in the WPS, including the following: a) base metal preparation CER 4-2-03 b) cleaning CER 4-2-03 c) preheat temperature N/A d) interpass temperature N/A e) temporary welds N/A f) backing strips/runoff tabs N/A g) joint preparation CER 4-2-03 Record IR number: 021052-S-104	4-2-03 CER
1.3	Structural Welding FIELD WELDS ONLY	5060 and SPC-389 Appendix C, drawing 519933	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: 021052-S-104	4-2-03 CER

CONSTRUCTION INSPECTOR PLANNING PACKAGE

IP No. 21052-S-07 Rev. 0											
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria	Method/Procedure Reference	Verify	Instructions	Complete	Initial Date	4-9-03	CEA	4-9-03	CEA
1.4	Structural Welding FIELD WELDS ONLY	S060 and SPC-389 Appendix A, drawing 519933	Random	Verify	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 021052-S-104	4-9-03	CEA	4-9-03	CEA	4-9-03	CEA
1.5	Structural Welding FIELD WELDS ONLY	S080 and SPC-389 Appendix A, drawing 519933	Visual TPR-4981, Appendix D	Verify	Verify that bolting has been torqued to the specified torque value. Record IR number: 021052-S-104 Note: a pre-installation test is required per AISC.	4-9-03	CEA	4-9-03	CEA	4-9-03	CEA
2.0	Bolting	SPC-389 Appendix A, drawing 519933	Verify 100% Item 1.1, 2.1, 2.3, 2.7, and Checklist 414.A29, 2.8, 3.2, 5.1 or 5.2 ONLY	Verify 100%	Verify that the shim material has been installed per the drawing. Record IR number: 021052-S-104	4-9-03	CEA	4-9-03	CEA	4-9-03	CEA
3.0	Shims	SPC-389 Appendix A, drawing 519933	Verify 100%	Verify 100%	Verify that the outer boot has been installed to the RCS per the drawing and PLN-1076. Record IR number: 021052-S-104	4-9-03	CEA	4-9-03	CEA	4-9-03	CEA
4.0	Outer Boot	SPC-389 Appendix A, drawing 519933 and PLN-1076	Verify 100%	Verify 100%	Verify that no suspect / counterfeit items have been utilized. Record IR number: 021052-S-104	4-9-03	CEA	4-9-03	CEA	4-9-03	CEA
5.0	General	MCP-9110	Verify	Verify	Verify that materials / items are segregated based on quality level, with no co-mingling of quality levels. Record IR number: 021052-S-104	4-9-03	CEA	4-9-03	CEA	4-9-03	CEA
6.0	General	MCP-9436 App. A, B & C	Random	Verify	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: 021052-S-104	4-9-03	CEA	4-9-03	CEA	4-9-03	CEA
6.1	General	MCP-9436 App. A, B & C	Random	Verify	Verify that all inspections have been completed and forward this inspection plan to the GE for closure. Record IR number: 021052-S-104	4-9-03	CEA	4-9-03	CEA	4-9-03	CEA
7.0		MCP-2482	Verify	Verify		4-9-03	CEA	4-9-03	CEA	4-9-03	CEA

INSPECTION PLAN GENERAL NOTES

CONSTRUCTION INSPECTOR PLANNING PACKAGE

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION/ ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION W E DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A 'GENERAL INSPECTOR'.
- 15) CHECKLISTS ARE BEING PILOTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION/ REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE.

22-0357716 LMIT

CONSTRUCTION INSPECTION WANNING PACKAGE

2003-03-11
2003-03-11

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Final QE Review: _____

Date: _____

WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: <i>K.L. Signature for S.A.O.</i>	QE: Ron Staynates 11/11/02 <i>R. Staynates</i>
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (WES PENETRATION ACTIVITIES)			Release Date: _____
Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2)			

IP No. 21052-M-05		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS.	
1.0	General	TPR-6416	Verify 100%	Verify that Final Inspection has been performed per 21052-R-02 on the items being inspected.	
2.0	WES Penetrations PIPING	Drawing P-2	Verify 100% Checklist 414.A20, Items 1.1, 1.2, 2.1, 2.2, 2.5, 3.1, 5.1 or 5.2 only	Verify that any WES Fabric Penetrations have been sealed in accordance with the approved sealing method (I.E. Vendor data or FCR/DCN).	
2.1	WES Penetrations FIRE PROTECTION	Drawing FP-4	Verify 100% Checklist 414.A20, Items 1.1, 1.2, 2.1, 2.2, 2.5, 3.1, 5.1 or 5.2 only	Verify that any WES Fabric Penetrations have been sealed in accordance with the approved sealing method (I.E. Vendor data or FCR/DCN).	
2.2	WES Penetrations HVAC	Drawing HV-6 & 7	Verify 100% Checklist 414.A20, Items 1.1, 1.2, 2.1, 2.2, 2.5, 3.1, 5.1 or 5.2 only	Verify that any WES Fabric Penetrations have been sealed in accordance with the approved sealing method (I.E. Vendor data or FCR/DCN).	
2.3	WES Penetrations ELECTRICAL	Drawing E-4, 9, 11, 12, 13, 19, 20, 21 & 22	Verify 100% Checklist 414.A20, Items 1.1, 1.2, 2.1, 2.2, 2.5, 3.1, 5.1 or 5.2 only	Verify that any WES Fabric Penetrations have been sealed in accordance with the approved sealing method (I.E. Vendor data or FCR/DCN).	

22-0358240 LMIT

IP No. 21052-M-05		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
2.4	WES Penetrations LSS	Drawing LSS-5	Verify 100% Checklist 414.A20, Items 1.1, 1.2, 2.1, 2.2, 2.5, 3.1, 5.1 or 5.2 only	Verify that any WES Fabric Penetrations have been sealed in accordance with the approved sealing method (I.E. Vendor data or FCR/DCN).	
2.5	WES Penetrations I & C	Drawing IN-13 & 31	Verify 100% Checklist 414.A20, Items 1.1, 1.2, 2.1, 2.2, 2.5, 3.1, 5.1 or 5.2 only	Verify that any WES Fabric Penetrations have been sealed in accordance with the approved sealing method (I.E. Vendor data or FCR/DCN).	
3.0	WES Penetrations	MCP-9110	Verify Random	Verify that no suspect / suspect items have been utilized. Record IR number:	
4.0	General	MCP-9436 App. A, B & C	Verify Random Checklist 414.A33	Verify that materials / items are segregated based on quality level, with no co-mingling of quality levels. Record IR number:	
4.1	General	MCP-9436 App. A, B & C And STD-7008	Verify Random Checklist 414.A33	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number:	
5.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.09, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY, ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, UNE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.W OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.

22-0358241 LIMIT

- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS WILL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".
- 15) CHECKLIST 414.A15 IS BEING PILOTTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE,

CONSTRUCTION INSPECTION PLANNING PACKAGE ORIGINAL

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Final QE Review:

Date:

WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: <i>[Signature]</i>	QE: Ron Staymates 10/03/02
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility Structures			Release Date: 10/03/02
Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2)			

P NO. 21052-M-01		Rev. 3	Clarified attribute 5 1 Nelson stud welding		
Item No.	Process/Item/ Material or Equipment	Acceptance criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION.	
				ALL WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS.	
1.0	Structural Welding FIELD WELDS ONLY	5060, pg 3 line 25 thru 36	Verify Random	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: 021052-S-025 021052-M-137 5-7-03 CER	12-11-02 CER
1.1	Structural Welding FIELD WELDS ONLY	5060, pg 4 line 30 thru 37	Verify Random	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number: 021052-S-075 021052-M-137 5-7-03 CER	12-11-02 CER
1.2	Structural Welding FIELD WELDS ONLY	5060, pg 5 line 11 thru 44 & pg 6 line 1 thru 35	Verify Random	Verify that the welding process is being performed in accordance with the parameters defined in the WPS (C-3.5 or 2.11 carbon steel, C-3.04 or 2.12 stainless steel, S 2.24 stainless or alternate WPS per approved FCR's), including the following: a) base metal preparation 12-11-02 CER b) cleaning 12-11-02 CER c) preheat temperature 12-11-02 CER d) interpass temperature 12-11-02 CER e) temporary welds 12-11-02 CER f) backing strips/runoff tabs 12-11-02 CER g) joint preparation 12-11-02 CER Record IR number: 021052-S-025	12-11-02 CER For C/S welding only

C/S welding only

CONSTRUCTION INSPECTION PLANNING PACKAGE

IIP NO. 21052-M-01		Rev. 3	Varified attribute 5.1 Nelson Stud welding		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.2.1	Structural Welding FIELD WELDS ONLY PER PCN FS-6	15060, pg 5 line 11 thru 44 & pg 6 line 1 thru 35	Verify Random	Verify that the welding process is being performed in accordance with the parameters defined in the WPS (C-3.5 or 2.11 carbon steel, CC-3.5 for 2.11 carbon to stainless steel, S 2.24 stainless or alternate WPS per approved FCR's), including the following: a) base metal preparation 12-11-02 CER b) cleaning 12-11-02 CER c) preheat temperature 12-11-02 CER d) interpass temperature 12-11-02 CER e) temporary welds 12-11-02 CER f) backing strips/runoff tabs 12-11-02 CER g) joint preparation <u>CS welding only</u> Record IR number: <u>021052-S-025</u>	12-11-02 CER CS welding 09/15
1.2.2	Structural Welding FIELD WELDS ONLY PER DCN FS-6	5060, pg. 7 line 34 thru 38	TPR-4981, Appendix D Visual 100% Static Loaded HOLD POINT	Visually inspect welds per AWS D1.1. Record IR Number: <u>021052-S-025</u>	021052-M-127 5-7-03 CER 12-11-02 CER
1.3	Structural Welding FIELD WELDS ONLY	5060, pg 6 line 37 thru 42 & pg 7 line 1 thru 12	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: <u>021052-S-025</u>	12-11-02 CER
1.4	Structural Welding FIELD WELDS ONLY	5060, pg 7 line 14 thru 17	Verify Random	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: <u>021052-S-025</u>	12-11-02 CER
1.5	Structural Welding FIELD WELDS ONLY	5060, pg. 7 line 34 thru 38	TPR-4981, Appendix D Visual 100% Static Loaded HOLD POINT	Visually inspect welds per AWS D1.1. Record IR Number: <u>021052-S-025</u>	021052-M-127 5-7-03 CER 12-11-02 CER
2.0	Structural Steel and Misc. Metals Frame	5100, pg 2 line 1 thru 5 & pg 4 line 11 thru 21 and line 35 thru 43 and 13200 pg 2 line 20 thru 36	Verify Random Checklist 414.A15	Verify that the structural steel is erected per the erection plan, manufacturers recommendations and final approved shop drawings. Record IR number: <u>02162-M-006</u>	9-20-02 CER

CONSTRUCTION INSPECTION PLANNING PACKAGE

No. 21052-M-01		Rev. 3	Clarified attribute 5.1 Note on Stud welding		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
2.1	Structural Steel and Misc. Metal Floor Decking		Verify Random Checklist 414.A15	Verify that the structural steel is erected per the erection plan, manufacturers recommendations and final approved shop drawings. Record IR number: 021052-S-025	12-11-02 CEK
2.2	Structural Steel and Misc. Metal Floor Plater		Verify Random Checklist 414.A15	Verify that the structural steel erected per the erection plan, manufacturers recommendations and final approved shop drawings. Record IR number: 021052-S-025 021052-S-009 R# 4/12/03	12-11-02 CEK
2.3	Structural Steel and Misc. Metal Shoring Box		Verify Random Checklist 414.A15	Verify that the structural steel is erected per the erection plan, manufacturers recommendations and final approved shop drawings. Record IR number: NCR-28751, 28757, 28861 4003	11-7-02 CEK
2.4	Structural Steel and Misc. Metal	5100 pg 4 line 26 to 29	Verify Random	Verify that bolted connections have been installed using "snug tight" for all connections except those indicated as moment connections on drawings S-3 and S-4. Record IR number: 02152-M-006	9-20-02 CEK
2.5	Structural Steel and Misc. Metal	5100 pg 4 line 26 to 29	Verify 100%	Verify that bolted connections have been installed using "twist off type" assemblies for the moment connections indicated on drawings S-3 and S-4. Record IR number: 02152-M-006, S-025	9-20-02 CEK
2.5	Structural Steel and Misc. Metal	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: 021052-S-025	12-11-02 CEK
3.0	Stainless Structural Steel (ref: spec. 5060 criteria listed above)	5101 pg 2 line 31	Verify Random	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: N/A	12-11-02 CEK
3.1	Stainless Structural steel (ref: Spec. 5060 criteria listed above)	5101 pg 2 line 31	Verify Random	Verify that the filler metal is the correct type per the WPS and that it is traceable to an actual CMTR with heat number. Record IR number: N/A	12-11-02 CEK

① NO STAINLESS STRUCTURAL STEEL WELDING PERFORMED. Ray Daymaster 4/8/03
CEK 4-8-03

CONSTRUCTION INSPECTION PLANNING PACKAGE

P No. 21052-M-01		rev. 3	Clarified attribute 5.1 Nelson Stud welding		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
3.2	Stainless Structural Steel (ref: Spec. 5060 criteria listed above)	5101 pg 2 line 31	Verify Random	Verify that the welding process is being performed in accordance with the parameters defined in the WPS (S-3.16 stainless or CS-3.04 carbon to stainless), including the following: a) base metal preparation b) cleaning c) preheat temperature d) interpass temperature e) temporary welds f) backing strips/runoff tabs g) joint preparation Record IR number: <i>N/A</i>	<i>DPH/1/03</i>
9.3	Stainless Structural Steel (ref: Spec. 5060 criteria listed above)	5101 pg 2 line 31	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs Record IR number: <i>N/A</i>	<i>DPH/1/03</i>
3.4	Stainless Structural Steel (ref: Spec. 5060 criteria listed above)	5101 pg 2 line 31	Verify Random	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: <i>N/A</i>	<i>DPH/1/03</i>
3.5	Stainless Structural Steel (ref: Spec. 5060 criteria listed above)	5101 pg 2 line 31	Visual 100% HOLD POINT Static Loaded	Visually inspect welds per AWS D1.6 utilizing the attached acceptance criteria section 6.28 (Statically Loaded) Record IR Number: <i>N/A</i>	<i>DPH/1/03</i>
3.6	Stainless Structural Steel	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: <i>N/A</i>	<i>DPH/1/03</i>
4.0	GFE Building Erection WES	13200 pg 2 line 20 thru 36	Verify Random Checklist 414.A15	Verify that the WES structural framing, roof trusses, wind braces, gable roof trusses, doors, louvers, etc. (excluding the fabric cover) is erected per the approved design drawings and manufacturers recommendations. Record IR number: <i>021052-M-039</i>	<i>1-7-03</i> <i>CER</i>
4.1	GFE Building Erection WES FIELD WELDS	Universal Fabric Structures Approved Shop Drawings	Visual 100% TPR-4981 Appendix D HOLD POINT Static Loaded	Visually inspect field welds utilizing the criteria in items 1.0 thru 1.4 above. Record IR number: <i>021052-M-039</i>	<i>1-7-03</i> <i>CER</i>

CONSTRUCTION INSPECTION PLANNING PACKAGE

P No. 21052-M-01		Rev. 3	Clarified attribute 5.1 Nelson Stud welding		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
4.2	GFE Building Erection WES	Universal Fabric Structures Approved Shop Drawings and Manufacturers Criteria	Verify Random	Verify that A-325 bolted connections have been installed using manufacturers recommended criteria. Record IR number: 021052-M-039	1-7-03 CER
4.3	GFE Building Erection WES	Universal Fabric Structures Approved Shop Drawings and Manufacturers Criteria	Verify Random	Verify that the roof and side wall fabric has been installed per the manufacturers recommended criteria. Record IR number: 021052-M-039	1-7-03 CER
4.3.1	GFE Building Erection WES	Universal Fabric Structures Approved Shop Drawings and Manufacturers Criteria	Verify Random	Verify that all seam welding performed in the field is in accordance with the approved manufacturers instructions and the welder is qualified, including the roof, side walls and end walls. Record IR number; 021052-M-039	1-7-03 CER
4.4	GFE Building Erection WES	Universal Fabric Structures Approved Shop Drawings and Manufacturers Criteria	Verify Random	Verify that the end wall fabric has been installed per the manufacturers recommended criteria. Record IR number: 021052-M-039	1-7-03 CER
4.5	GFE Building Erection WES	Universal Fabric Structures Approved Shop Drawings and Manufacturers Criteria	Verify Random Checklist 414.A15	Verify that the WES tension bars (including sleeves, tabs, tubes, etc.) are installed per the approved design drawings and manufacturers recommendations. Record IR number 021052-M-039	1-7-03 CER
4.6	GFE Building Erection WES	Universal Fabric Structures Approved Shop Drawings and Manufacturers Criteria	Verify 100%	Verify that the WES fabric (roof, side wall and end wall) is free of any tears, rips, or other damage. Record IR number: 021052-M-039	1-7-03 CER

CONSTRUCTION INSPECTION PLANNING PACKAGE

P No. 21052-M-01		Rev. 3	Clarified attribute 5.1 Nelson Stud welding, added 7.0		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
4.7	GFE Building Erection WES	MCP-9110	Verify 100%	Verify that no suspect / counterfeit items have been utilized. Record IR number: 021052-M-039	1-7-03 CER
5.0	GFE Building Erection RCS	13200 pg 2 line 20 thru 36	Verify Random HOLD POINTS a) Start of Erection, b) 50% Erection Completion c) Erection Completion Checklist 414.A15	Verify that the RCS modular panel system (Personnel Monitoring Area, Personnel Access Area, Transfer Vestibule Overburden Area, Emergency Exit Area and the RCS Area) is erected per the approved design drawings and manufacturers recommendations. NOTE: Idaho Professional Engineer must be present at the start of erection, at approximately 50% completion and at completion of construction Record IR number: 021052-S-040	
5.0.1	GFE Building Erection RCS	13200 pg 2 line 20 thru 36	Verify Random Checklist 414.A15	Verify that the RCS catwalk system is erected per the approved design drawings and manufacturers recommendations. Record IR number: 021052-S-040	
5.1	GFE Building Erection RCS	Kelly Klosure Approved Shop Drawings	Visual 100% (welding only) Random (alternate method) HOLD POINT	Verify that the floor stud welds (1/2 in., 5/8 in. and 3/4 in.) are completed utilizing approved Nelson Studs, approved Nelson Stud Gun and qualified welders... NCR-29425 Record IR number: 021052-S-040 NOTE 1: 3/16 in. Plate may require slotting to allow for installation of the studs to the 7/16 in. Plate. This shall be documented on an approved FCR. NOTE 2: Alternate methods of fastening the RCS to the floor plate may be utilized. This shall be documented on an approved FCR. 021052-S-040	1-9-03 CER 1-9-03 CER
5.2	GFE Building Erection RCS	Kelly Klosure Approved Shop Drawings	Verify Random	Verify that the Base Gasket has been installed between the floor and the RCS frame. Record IR number: 021052-S-040	1-9-03 CER
5.3	GFE Building Erection RCS	Kelly Klosure Approved Shop Drawings	Verify Random	Verify that the caulk has been installed between the connection joints prior to assembly, when required by erection drawings. (Caulking between connection joints may not be required.) Record IR number: 021052-S-040	1-9-03 CER

① N/A PER UDR-34846
REV. 0 1-21-03

CONSTRUCTION INSPECTION PLANNING PACKAGE

IP No. 21052-M-01		Rev. 3	Clarified attribute 5.1 Nelson Stud welding, added 7.0		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
5.4	GFE Building Erection RCS	Kelly Klosure Approved Shop Drawings	Verify Random	Verify that caulk has been installed at all connection joints prior to initial pressure testing. Record IR number: 021052-S-040 1-9-03 CER	1-9-03 CER
5.5	GFE Building Erection RCS	Approved Test Plan	Verify 100% HOLD POINT	Witness initial pressure testing of the RCS. Deleted Per I/P 21052-M-12	N-A
5.6	GFE Building Erection RCS	Kelly Klosure Approved Shop Drawings	Verify Random	Verify that the tape has been installed over the connection joints after caulking and initial pressure testing. Deleted Per I/P 21052-M-12	N-A
5.7	GFE Building Erection RCS	Kelly Klosure Approved Shop Drawings	Verify Random	Verify that the stainless steel sheet installed on the RCS panels furnished by the supplier is being maintained in a clean condition and shows no evidence of scratches, dings, dents, etc. 021052-S-040	1-9-03 CER
5.8	GFE Building Erection RCS	Kelly Klosure Approved Shop Drawings and A-5	Verify Random	Verify that the stainless steel sheet has been installed as shown on approved erection drawings by the field with supplier furnished rivets. Record IR number: 021052-S-040	1-9-03 CER
5.9	GFE Building Erection RCS	Kelly Klosure Approved Shop Drawings	Verify Random	Verify that A-325 bolted connections (1/2 in. and 5/8 in.) have been installed using "snug tight". Record IR number: 021052-S-040	1-9-03 CER
5.10	GFE Building Erection RCS	Approved Test Plan	Verify 100% HOLD POINT	Witness final pressure testing of the RCS. Deleted Per I/P 21052-M-12	N-A
5.11	GFE Building Erection RCS	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: 021052-S-040	1-9-03 CER
6.0	General	MCP-9436 App. A, B & C	Verify Random	Verify that materials / items are segregated based on quality level, with no commingling of quality levels. Record IR number: 021052-S-040	1-9-03 CER

CONSTRUCTION INSPECTION PLANNING PACKAGE

IP No. 21052-M-01		Rev. 3	Clarified attribute 5.1 Nelson Stud welding		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
6.1	General	MCP-9436 App. A, B & C And STD-7006	Verify Random	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: <u>02-1052-S-040</u>	<u>1-9-03</u> <u>CFE</u>

CIP NUMBER: 21052-M-01 INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03. "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.451
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE WILL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (I.E. BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538/ 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TROU
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".

414.81#
09/08/97
Rev. #01

CONSTRUCTION INSPECTION PLANNING PACKAGE

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- 15) CHECKLIST 414.A15 IS BEING PILOTED IN THIS INSPECTION PLAN (REF. TPR-4921), AND SUBJECT TO CLARIFICATION / REVISION WRING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE.

CONSTRUCTION INSPECTION PLANNING PACKAGE

Final QE Review:

Date: 11-22-02

WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: STEVE DAVIES PER EMAIL 10/21/02 (COPY ATTACHED)	QE: Ron Slaymales 10/03/02 <i>FS</i>
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility Structures Stack-Low Safety Consequence (Q-3)			Release Date: 10/22/02

IP No. 21052-M-02		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS.	
1.0	Structural Welding FIELD WELDS ONLY	5060, pg 3 line 25 thru 36 VDR Number 34820 and 34825 (copy attached)	Verify Random	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: 021052-S-015	11-15-02 CER
1.1	Structural Welding FIELD WELDS ONLY	5060, pg 4 line 30 thru 37 VDR Number 34820 and 34825 (copy attached)	Verify Random	Verify that the filler metal is the correct type per the WPS and that it is traceable to a typical CMTR. Record IR number: 021052-S-015	11-15-02 CER
1.2	Structural Welding FIELD WELDS ONLY	5060, pg 5 line 11 thru 44 & pg 6 line 1 thru 35 VDR Number 34820 and 34825 (copy attached)	Verify Random	Verify that the welding process is being performed in accordance with the parameters defined in the WPS (C-3.5 or 2.11 carbon steel, CS-3.04 or 2.7 carbon to stainless steel, S 2.24 stainless or alternate WPS per approved FCR's), including the following: a) base metal preparation b) cleaning c) preheat temperature d) interpass temperature e) temporary welds f) backing strips/runoff tabs g) joint preparation Record IR number: 021052-S-015	11-15-02 CER 11-15-02 CER 11-15-02 CER 11-15-02 CER 11-15-02 CER 11-15-02 CER 11-15-02 CER 11-15-02

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IP No. 21052-M-02		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.3	Structural Welding FIELD WELDS ONLY	5060, pg 6 line 37 thru 42 & pg 7 line 1 thru 12 VDR Number 34820 and 34025 (copy attached)	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: 021052-S-015 <i>No Weld Repairs Required</i>	11-15-02 CER
1.4	Structural Welding FIELD WELDS ONLY	5060, pg 7 line 14 thru 17 VDR Number 34820 and 34825 (copy attached)	Verify Random	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 021052-S-015	11-15-02 CER
1.5	Structural Welding FIELD WELDS ONLY	5080, PA. 7 line 34 thru 38 VDR Number 34820 and 34825 (copy attached)	TPR-4981, Appendix D Visual 100% Static Loaded HOLD POINT	Visually inspect welds per AWS D1.1. Record IR Number: 021052-S-015	11-15-02 CER
2.0	Structural Steel and Misc. Metals	5100, pg 2 line 1 thru 5 & pg 4 line 11 thru 21 and line 35 thru 43 and 13200 pg 2 line 20 thru 36 VDR Number 34820 and 34825 (copy attached)	Verify Random Checklist 414.A15	Verify that the stack is erected per the erection plan and final approved shop drawings. Record IR number: 021052-S-015	11-15-02 CER
2.1	Structural Steel and Misc. Metal	16100 pg 4 line 28 to 29 VDR Number 34820 and 34825 (copy attached)	Verify Random	Verify that bolted connections have been installed using "snug tight" for all connections. Record IR number: 021052-S-015	11-15-02 CER

CONSTRUCTION INSPECTION PLANNING PACKAGE

ORIGINAL

IP No. 21052-M-02		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
3.0	Structural Bolts	Drawing C-3	Verify/100%	Verify that the new nuts to be installed to the existing anchor bolts have been approved and are traceable to the vendor data. Deleted Per Record IR number: American Fabrication Drawing F-1.	N-A P 11/14/10
4.0	Structural Steel and Misc. Metal	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number:	N-A P 11/14/10
6.0	General	MCP-9436 App. A, B & C	Verify Random	Verify that materials are segregated based on quality level, with no commingling of quality levels. Record IR number:	N-A P 11/14/10
6.1	General	MCP-9436 App. A, B & C And STD-7006	Verify Random	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (Use and use by marking, tagging or other unique identifier) Record IR number:	N-A P 11/14/10
7.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure. 021052-S-015	11-15-02 CER

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 'VISUAL INSPECTION REPORT' AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43.432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COW OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 & 698.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR NM'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:

22-0358188 LMIT

- A) ANCHOR BOLT PLACEMENT
- B) ANCHOR BOLT TORQUE
- C) LOCATION
- D) ELEVATION
- E) ORIENTATION

- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC. PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".
- 15) CHECKLIST 414.A15 IS BEING PILOTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING M E CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THERE.

7/6/02
7/10/02
7/10/02

CONSTRUCTION INSPECTION PLANNING PACKAGE

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Final QE Review:

Date: 10/11/02

WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: DAVID STEPHENS / MELISSA FUNK	QE: Ron Staymates 07/8/02
Activity/Project Description: OU 7-10 Glovebox Excavator Method Mockup Structure (RCS & Shoring Box)			Release Date: 7/10/02

APPROVED VIA EMAILS, DATED 7/10/02 (COPIES ATTACHED)

Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION					
1.0	RCS	AWS D 1.1	TPR-4981, Appendix D Visual 100%	Visually inspect welds per AWS D1.1. Note: Weld size is to be based on member thickness. Record IR Number: 21052-S-007	9-25-02 CEH
2.0	RCS	AISC	Verify 100%	Verify that bolted connections have been installed using "snug tight" for all connections. Record IR number: 21052-S-004 & 21052-M-008	8-27-02 CEH
3.0	Shoring Box	AWS Drawing 519925 and 519926	TPR-4981, Appendix D Visual 100%	Visually inspect welds per AWS D1.1. Record IR Number: 21052-S-007	8-27-02 CEH
4.0	Shoring Box	AISC Drawing 519925 and 519926	Verify 100%	Verify that bolted connections have been installed using "turn of the nut" for all ASTM A-325 connections. Record IR number: 21052-S-004	8-27-02 CEH
5.0	Materials	MCP-8110	Verify 100%	Verify that no suspect / counterfeit items have been utilized. Record IR number: 21052-S-004 & 21052-M-008	10-7-02 CEH

CIP NUMBER: 21052-MOCKUP-01 INSPECTION PLAN GENERAL NOTES

- UTILIZE SKETCHES SK-1, 4 PAGES TOTAL AND FAX DATED 7/8/02 FROM D.L. STEPHENS TO RON STAYMATES FOR ADDITIONAL INFORMATION RELATED TO THE OVERALL CONFIGURATION AND MODIFICATIONS.
- ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY AND FORWARDED TO QE FOR REVIEW.
- WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 698.

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- 7) A U BLANKS HAVE BEEN COMPLETED OR NM'D.
- 8) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 9) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 10) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".
- 11) CHECKLIST 414.A15 IS BEING PILOTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THERE,

LATE
ENTRY
APPROVED: *[Signature]* 8/14/02
QUALITY ENGINEER / DATE

LATE
ENTRY
DAVID STEPHENS 8/14/02
REQUESTER / DATE

CONSTRUCTION INSPECTION PLANNING PACKAGE

Page 1 of 2

Final QE Review:

Date:

WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: STEVE DAVIES PER EVAL	QE: Ron Staymates 08/21/02
Activity/Project Description: Receipt inspection of E7018 Weld Rod for the OU 7-10 Glovebox Excavator Method			Release Date: 8/20/02

IP No. 21052-R-01		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.0	Weld Rod	FCR-02-036-05	Verify 100%	Verify that the typical CMTR's have been submitted thru the VDS system and are approved. 1) 262609, 1/8" E7018, QA-93317 2) 252691 3/32" E7018, QA-93318 3) 222696, 3/32" E7018, QA-93318	8-27-02 CER
2.0	Weld Rod	FCR-02-036-05	Visual TPR-6416 100%	Perform receipt inspection and re-tag material containers for lot 262609, 1/8", E7018, QA-93317 at CPP-698 warehouse as Q2. Record quantity inspected: R# 8-15-03	8-27-02 CER
3.0	Weld Rod	FCR-02-036-05	Visual TPR-6416 100%	Perform receipt inspection and re-tag material containers for lot 252691 3/32" E7018, QA-93318 at CPP-698 warehouse as Q2. Record quantity inspected: R# 8-15-03	8-27-02 CER
4.0	Weld Rod	FCR-02-036-05	Visual TPR-6416 100%	Perform receipt inspection and re-tag material containers for lot 222696, 3/32" E7018, QA-93318 at CPP-698 warehouse as Q2. Record quantity inspected: R# 8-15-03	8-27-02 CER

CIP NUMBER 21052-R-01
INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION/ ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 3) MATERIAL SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 4) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 5) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 6) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 7) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 8) ALL ATTRIBUTES IN THIS PLAN. EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A 'GENERAL INSPECTOR'.

Steven A Davies
08/21/02 12:32 PM

To: Ronald L Staymates/STAYRL/CC01/NEEL/US@INEL
cc: Curtis E Reay/CR6/LMITCO/NEEL/US@INEL, Darin R
Johnson/JOHNDR/CC01/NEEL/US@INEL, David S
Behrens/DSB/CC01/NEEL/US@INEL, J S
Stone/JSTONE/CC01/NEEL/US@INEL

Fax to:
Subject: Re: PIT-9 Weld Rod Upgrade

021052-R-01
Pg. 2 of 2
8/21/02

Inspection Plan is Approved.

Ronald L Staymates



Ronald L Staymates
08/21/02 09:56 AM

To: Steven A Davies/SDV/CC01/NEEL/US@INEL, David S
Behrens/DSB/CC01/NEEL/US@INEL, Darin R
Johnson/JOHNDR/CC01/NEEL/US@INEL
cc: J S Stone/JSTONE/CC01/NEEL/US@INEL, Curtis E
Reay/CR6/LMITCO/NEEL/US@INEL

Fax to:
Subject: PIT-9 weld Rod Upgrade

Attached are the revised FCR and Inspection Plan for your review.

The following actions need to happen:

- 1) FCR needs to be processed, if found to be acceptable.
- 2) FCR number needs to be emailed to me for incorporation into the inspection plan.
- 3) Steve Davies needs to email me approval of the inspection plan, if acceptable. I will add the FCR number to the plan upon receipt of this information.
- 4) The CMTR's need to be placed into the VDS system for review and approval. I have the copies for this action to be completed.
- 5) The CMTR's need to be approved prior to performing the inspection
- 6) I will forward an electronic copy of the inspection plan to Curtis Reay for completion. Then I will mail the hard copy for his signature.
- 7) Curtis Reay will perform the inspection and re-tag the material using the electronic copy. The hardcopy will then be completed by Curtis Reay upon receipt. Curtis will then return the completed inspection plan to me for final review and closure.

Ron Staymates
Construction QA
Phone 6-3584 / Fax 6-2947 / WCB MS 3535
Email: stayrl

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Final QE Review:

Ron Staymates

Date:

4-30-03

WO/SC/PO No. S00-021052	Requester: S Davies	Requester Approval: <i>S Davies 12/11/02</i>	QE: Ron Staymates
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility Package Receipt Inspection Activities			Release Date: 12/11/02 12-11-02 <i>R 12/11/02</i>

		Rev. 3	Rev. 3 Provided further clarification on items to be receipt inspected. Added couplings, pipe nipples and pipe plugs to Atlas Mechanical. Added separate line items for each type of material.		
		Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
N/A	N/A	N/A	N/A	Subcontractor material that is safety class (Q-1), safety significant (Q-2) or low safety consequence (Q-3) requires receipt inspection. This includes the following items, as a minimum: (see Form 414.02 & 414.70 for details) 1) Inspector shall record the following information on the Inspection Report: A) Item description B) VDS item number, as applicable C) Quantity inspected D) Serial numbers/unique identifying numbers	N/A
1.0	S/S Ductwork (Atlas Mechanical)	PR-6416	Visual / 100%	Verify the following conditions, as applicable 1) Damage 2) Cleanliness 3) protective coating 4) markings / identification 5) dimensional (random) - utilize approved fab drawings, catalogue cuts, etc. 6) surface condition / finish 7) weld appearance 8) end protection 9) end preparation 10) storage level & segregation per MCP-9436 (this is not an accept/reject attribute. If material is not being segregated, document on an IR and forward the IR to the QE) IR number: 02/052-H-010	16 1-3-03
1.1	PerVDS	TPR-6416	Visual / 100%	Verify that the material is traceable to the associated documentation, and that it complies with the approved vendor data. IR number: 02/052-H-000011	16 1-3-03

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Rev. #01

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IP No. 21052-R-02		Rev. 3	Rev. 3 Provided further clarification on items to be receipt inspected. Added couplings, pipe nipples and pipe plugs to Atlas Mechanical. Added separate line items for each type of material.		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.2	Per Form 414.02 and / or 414.70	TPR-6416	Verify / 100%	Apply a QC Accept tag to the items, where practical. When this is not feasible, the tag shall be placed with the inspection report for future reference. NOTE: All items accepted shall be uniquely identified to indicate acceptance. This identification shall consist of either placing a tag, where possible or by applying the QA number and Initial/date physically on the item with a black indelible marker.	11-5-88 JL

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IP No. 21052-R-02		Rev. 3	Rev. 3 Provided further clarification on items to be receipt inspected. Added couplings, pipe nipples and pipe plugs to Allas Mechanical. Added separate line items for each type of material		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
2.0	A) RCS & Glovebox bulkhead fittings * Ref: CGI form for p/n W3ZA5, dated 12/3/02	TPR-6416	Visual / 100%	Verify the following conditions, as applicable 1) Damage 2) Cleanliness 3) protective coating 4) markings / identification 5) dimensional (random)- utilize approved fab drawings catalogue cuts, etc. 6) surface condition / finish 7) weld appearance 8) end protection 9) end preparation 10) storage level & segregation per MCP-9436 (this is not an accept/reject attribute. If material is not being segregated, document on on IR and forward the IR to the QE) IR number: 021052-1-021	12-3-02 26
	B) Couplings* Ref: CGI form for DWG 522717, dated 12/3/02	TPR-6416	Visual / 100%		KB 12-3-02
	C) Pipe plugs* Ref: CGI form for DWG 522717, dated 12/3/02	TPR-6416	Visual / 100%		KB 12-3-02
	D) Motorized Damper* Ref: CGI form for Spec. 15801 & DWG 522712, dated 12/12/02	TPR-6416	Visual / 100%		KB 1-2-03 021052-R-035
	E) Flanges*	TPR-6416	Visual / 100%		N/A
	F) Bolts/Nuts* Ref: CGI form for Spec. 15801, dated 12/11/02	TPR-6416	Visual / 100%	Fabricated in-house, No CGI form Required	KB 12-5-02

CONSTRUCTION INSPECTION PLANNING PACKAGE

No. 21052-R-02		lev. 3	lev. 3 Provided further clarification on items to be receipt inspected. Added couplings, pipe nipples and pipe plugs to Atlas technical. Added separate line items for each type of material.		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
2.1	G) Gaskets* Ref: CGI form for Spec. 15801, dated 12/11/02 (Mechanical) Mechanical	'PA-6416	'visual / 100%		LB 12-16-02
		'PR-6416	'visual / 100%	'erify that the material is traceable to the associated documentation, and that it complies with the approved vendor data. IR number: 021052-V-010-011-015 Rb 8/16/03 SEE BREAKDOWN	LB 12-21-03
2.2	Per Form 431.53 & FCR-13223-2C	'MCP-3772 / 'PR-6416	'erify / 100%	'perform inspections specified on the CGI Form 431.53, for the items identified with an * and attach to this plan. Document inspections on an IR Form 414.03. Record IR numbers: 11052-V-021	LB 12-21-03
2.3	Per Form 414.02 and / or 414.70	'PR-6416	'erify / 100%	Apply a QC Accept tag to the items, where practical. When this is not feasible, the tag shall be placed with the inspection report for future reference. NOTE: All items accepted shall be uniquely identified to indicate acceptance. This identification shall consist of either placing a tag, where possible or by applying the QA number and initial/date physically on the item with a black indelible marker.	LB 12-21-03
3.0	A) RCS Bulkhead Fittings * Ref: CGI form for p/n WBZA5, dated 12/3/02 (DCNFP-10) (3D Fire Protection)	'PR-6416	'visual / 100%	'erify the following conditions, as applicable 11) Damage 12) Cleanliness 13) protective coating 14) markings / identification 15) dimensional (random) - utilize approved fab drawings, Catalogue cuts, etc. 16) surface condition / finish 17) weld appearance 18) end protection 19) end preparation 20) storage level & segregation per MCP-9436 (this is not an accept/reject attribute. If material is not being segregated, document on an IR and forward the IR to the QE) IR number: 021052-V-021-019 Rb 4/17/03	LB 12-5-02
3.1	Per VDS	'PR-6416	'visual / 100%	'erify that the material is traceable to the associated documentation, and that it complies with the approved vendor data. IR number: 021052-V-010-011-019 021052-V-019 Rb 4/17/03	LB 12-21-03

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IP No. 21052-R-02		Rev. 3	Rev. 3 Provided further clarification on items to be receipt inspected. Added couplings, pipe nipples and pipe plugs to Atlas Mechanical. Added separate line items for each type of material.		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
3.2	Per Form 431.53 & FCR-13223-20	MCP-3772 / TPR-6416	Verify / 100%	Perform inspections specified on the CGI Form 431.53, for the items identified with an * and attach to this plan. Document inspections on an IR Form 414.03. Record IR numbers: 021052-U-32 and 019	26 2-12-03
3.3	Per Form 414.02 and / or 414.70	TPR-6416	Verify / 100%	Apply a QC Accept tag to the items, where practical. When this is not feasible, the tag shall be placed with the inspection report or future reference. NOTE: All items accepted shall be uniquely identified to indicate acceptance. This identification shall consist of either placing a tag, where possible or by applying the QA number and initial/date physically on the item with a black indelible marker.	26 2-12-03
4.0	Weld Rod (Continental Steel)	TPR-6416	Visual / 100%	Verify the following conditions, as applicable: 1) Damage CER 4-21-03 2) Cleanliness CER 4-21-03 3) protective coating CER 4-21-03 4) markings / identification CER 4-21-03 5) storage level & segregation per MCP-9436 (this is not an accept/reject attribute. If material is not being segregated, document on an IR and forward the IR to the QE) CER 4-21-03 IR number: 021052-R-113	4-21-03 CER
4.1	Per VDS	TPR-6416	Visual / 100%	Verify that the material is traceable to the associated documentation, and that it complies with the approved vendor data. 1052-R-113	4-21-03 CER
4.2	Per Form 414.02 and / or 414.70	TPR-6416	Verify / 100%	Apply a QC Accept tag to the items, where practical. When this is not feasible, the tag shall be placed with the inspection report or future reference. NOTE: All items accepted shall be uniquely identified to indicate acceptance. This identification shall consist of either placing a tag, where possible or by applying the QA number and initial/date physically on the item with a black indelible marker. 021052-R-113 Green Tag	4-21-03 CER
5.0	Weld Rod (Warbonnet Electric)	TPR-6416	Visual / 100%	Verify the following conditions, as applicable: 1) Damage 2) Cleanliness ALL WELDING PERFORMED 3) protective coating BY ATLAS-SEE ATLAS 4) markings / identification WELD MAPS Pg 4/24/03 5) storage level & segregation per MCP-9436 (this is not an accept/reject attribute. If material is not being segregated, document on an IR and forward the IR to the QE) IR number:	N-A

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		Rev. 3	Rev. 3 Provided further clarification on items to be receipt inspected. Added couplings, pipe nipples and pipe plugs to Atlas Mechanical. Added separate line items for each type of material.		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
5.1	Per VDS	PR-6416	Visual / 100%	Verify that the material is traceable to the associated documentation, and that it complies with the approved vendor data. R number:	N-A
5.2	Per Form 414.02 and / or 414.70	PR-6416	Verify / 100%	Apply a QC Accept tag to the items, where practical. When this is not feasible, the tag shall be placed with the inspection report for future reference. NOTE: All items accepted shall be uniquely identified to indicate acceptance. This identification shall consist of either placing a tag, where possible or by applying the QA number and initial/date physically on the item with a black indelible marker.	N-A
6.0	Weld Rod (Atlas Mechanical)	PR-6416	Visual / 100%	Verify the following conditions, as applicable 1) Damage 2) Cleanliness 3) protective coating 4) markings / identification 5) storage level & segregation per MCP-9435 (this is not an accept/reject attribute. If material is not being segregated, document on an IR and forward the IR to the QE) R number: 021052-H-011	RB 1-22-03
6.1	Per VDS	TPR-6416	Visual / 100%	Verify that the material is traceable to the associated documentation, and that it complies with the approved vendor data. R number: 021052-H-011	RB 11-5-02
6.2	Per Form 414.02 and / or 414.70	TPR-6416	Verify / 100%	Apply a QC Accept tag to the items, where practical. When this is not feasible, the tag shall be placed with the inspection report for future reference. NOTE: All items accepted shall be uniquely identified to indicate acceptance. This identification shall consist of either placing a tag, where possible or by applying the QA number and initial/date physically on the item with a black indelible marker.	RB 11-5-02

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IP No. 21052-R-02		Rev. 3	Rev. 3 Provided further clarification on items to be receipt inspected. Added couplings, pipe nipples and pipe plugs to Atlas Mechanical. Added separate line items for each type of material.		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
7.0	Criticality Alarm System Components A) Light Poles* Ref: CGI form for DWGs 522684 & 522685, dated 10/3/02 B) Self tapping screws* Ref: CGI form for DWGs 522654 & 522685, dated 10/3/02 C) Conduit & Connectors* Ref: CGI form for SPC-389, 18610-2, dated 10/15/02	TPR-6416 TPR-6416 TPR-6416 TPR-6416	Visual / 100% Visual / 100% Visual / 100% Visual / 100%	Verify the following conditions, as applicable: 1) Damage 2) Cleanliness 2) protective coating 4) markings / identification 5) dimensional (random) - utilize approved fab drawings, catalogue cuts, etc. 6) surface condition / finish 7) weld appearance 8) end protection 9) end preparation 10) storage level & segregation per MCP-9436 [this is not an accept/reject attribute. If material is not being segregated, document on an IR and forward the IR to the QE] IR number: 021052-P-057	A.) 2/15/03 N/A SEE 21052-R-04 REPORT # 77 FOR 14-20 CAP SCREWS RB 4/24/03 EV TML

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IP No. 21052-R-02		Rev. 3	Rev. 3 Provided further clarification on items to be receipt inspected. Added couplings, pipe nipples and pipe plugs to Atlas Mechanical. Added separate line items for each type of material.	
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions
	D) Cable & wire Ret: CGI form for SPC-389, 16110- 2, line 25, dated 10/15/02 and CGI form for DWG 522770, dated 11/25/02	TPR-6416	Visual / 100%	See EA 021052-E-057
	E) Hangers and supports CGI form for DWG 522770, dated 11/25/02	TPR-6416	Visual / 100%	See EA 021052-E-088
	F) Conduit clamps & straps CGI form for DWG 522770, dated 11/25/02	TPR-6416	Visual / 100%	See EA 021052-E-057
	G) Channel & Spring nuts Ret: CGI form for DWG 522770, dated 11/25/02	TPR-6416	Visual / 100%	See EA 021052-E-088
Complete Initial/Date	D) See EA 021052-E-057			
	1/29/03			
	D) See EA 021052-E-088			
	2/18/03			
	E) See EA 021052-E-057			
	2/18/03			
	F) See EA 021052-E-088			
	1/24/03			
	G) See EA 021052-E-088			
	2/18/03			
	H) See EA 021052-E-088			
	2/18/03			

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IP No. 21052-R-02		Rev. 3	Rev. 3 Provided further clarification on item to be receipt inspected. Added couplings, pipe nipples and pipe plugs to Atlas Mechanical. Added separate line items for each type of material.		
Item	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
	H) Junction boxes & covers* CGI form for DWG 522770, dated 11/25/02 (Warbonnet Electric)	TPA-6416	Visual / 100%		N/A 4/21/03 4/22/03
7.1	Per VDS	TPR-6416	Visual / 100%	Verify that the material is traceable to the associated documentation, and that it complies with the approved vendor data. IR number: 021052-E-057	4/17/03
7.2	Per Form 431.53 & FCR-13223-20	MCP-3772 / TPA-6416	Verify / 100%	Perform inspections specified on the CGI Form 431.53, for the items identified with an * and attach to this plan. Document inspections on an IR Form 414.03. Record IR numbers: 021052-E-057	4/17/03
7.3	Per Form 414.02 and / or 414.70	TPR-6416	Verify / 100%	Apply a QC Accept tag to the items, where practical. When this is not feasible, the tag shall be placed with the inspection report for future reference. NOTE: All items accepted shall be uniquely identified to indicate acceptance. This identification shall consist of either placing a tag, where possible or by applying the QA number and initial/date physically on the item with a black indelible marker. 021052-E-057	4/17/03

CONSTRUCTION INSPECTION PLANNING PACKAGE

IP No. 21052-R-02		Rev. 3	Rev. 3 Provided further clarification on items to be receipt inspected. Added couplings, pipe nipples and pipe plugs to Atlas Mechanical. Added separate line items for each type of material.		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
8.0	A) Criticality Detector Cluster Frame	TPR-6416	Visual / 100%	Verify the following conditions, as applicable 1) Cleanliness 2) protective coating 3) dimensional (random) - li apj 3 lab drawli cuts,	LB 01-02-03
	B) Criticality Console Housing Frame	TPR-6416	Visual / 100%	4) surface condition / fl 5) weld appearance 6) end preparation	LB 1-02-03
	C) Light/Alarm Pale Supports	TPR-6416	Visual / 100%	7) end preparation	LB 1-02-03
	D) Criticality Alarm Supports	TPR-6416	Visual / 100%	8) IR number: 21052-8-03	LB 1-02-03
	E) Self tapping screws* Ref: CGI form for DWGs 522664 and 522665, dated 10/31/02	TPR-6416	Visual / 100%		LB 1-02-03
	F) Pipe Nipple* Ref: CGI form for DWGs 522664 and 522665, dated 10/31/02	TPR-6416	Visual / 100%		LB 1-02-03
	G) Pipe Sleeve* Ref: CGI form for DWGs 522664 and 522665, dated 10/31/02	TPR-6416	Visual / 100%		LB 1-02-03

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IP No. 2L052-R-02		Rev. 3	Rev. 3 Provided further clarification on items to be receipt inspected. Added couplings, pipe nipples and pipe plugs to Atlas Mechanical. Added separate line items for each type of material.		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedura Reference	Instructions	Complete Initial/Date
	H) Socket head cap screws* Ref: CGI form for DWGs 522864 and 522665, dated 10/31/02	TPA-6416	Visual / 100%		KB 2-17-03
	I) ¾ x 3-1/2 grade 8 bolts*	MCP-3772, rev. 5 4.1 Note (copy attached)	Verify 100%	Verify manufacturers markings per ASTM/ASME Specification	KB 2-17-03
	J) ¾ grade 8 nuts*	MCP-3772, rev. 5 4.1 Note (copy attached)	Verify 100%	Verify manufacturers markings par ASTM/ASME Specification	KB 2-17-03
	K) ¾ fiat washers*	MCP-3772, rev. 5 4.1 Note (copy attached)	Verify 100%	Verify manufacturers markings per ASTM/ASME Specification	KB 2-17-03
	L) Split Ring Lock Washers* Ref: CGI form for DWGs 522864 and 522665, dated 10/31/02 {Reference: FCR-13233-20, 13233-26 & DCN FP-19) (Steel Wast)	TPR-6416	Visual / 100%		KB 2-17-03 KB 2-17-03

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414.81# - 007

IP No. 21052-R-02		Rev. 3	Rev. 3 Provided further clarification on items to be receipt inspected. Added couplings, pipe nipples and pipe plugs to Atlas Mechanical. Added separate line items for each type of material.		
Item No.	Process/Item/Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
8.1	Per VDS	TPR-6416	Visual / 100%	Verify that the material is traceable to the associated documentation, and that it complies with the approved vendor data. IR number: <u>21052-R-6416</u>	<u>20</u> <u>2-17-03</u>
8.2	Per Form 431.53 & FCR-13223-20	MCP-3772 / TPR-6416	Verify / 100%	Perform inspections specified on the CGI Form 431.53, for the items identified with an * and attach to this plan. Document inspections on an IR Form 414.03. Record IR numbers: <u>21052-R-6416</u>	<u>20</u> <u>2-17-03</u>
8.3	Per Form 414.02 and / or 414.70	TPR-6416	Verify / 100%	Apply a QC Accept tag to the items, where practical. When this is not feasible, the tag shall be placed with the inspection report for future reference. NOTE: All items accepted shall be uniquely identified to indicate acceptance. This identification shall consist of either placing a tag, where possible or by applying the QA number and initial/date physically on the item with a black indelible marker.	<u>20</u> <u>2-17-03</u>
9.0	Inspection Plan	MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	<u>20</u> <u>4-24-03</u>

INSPECTION PLAN GENERAL NOTES

- IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC) TO PROVIDE TRACEABILITY TO THE ITEM.
- ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538/598.
- ALL BLANKS HAVE BEEN COMPLETED OR NIA'D.
- WHEN PERFORMING LIQUID PENETRANT EXAMINATION RECORD THE BATCH NUMBERS ON EITHER THE WELD HISTORY RECORD OR THE IR OR THE CIP.

CONSTRUCTION INSPECTION PLANNING PACKAGE

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- 11) ALL LINE CUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 12) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 13) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
- A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 14) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT ITEMS PER MCP-8110.
- 15) ALL ATTRIBUTES IN THIS PLAN EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY QUALIFIED PERSONNEL OTHER THAN A "GENERAL INSPECTOR".
- 16) WHEN CONFLICTS ARISE THAT PRECLUDE THE INSPECTOR FROM PERFORMING A VERIFICATION ACTIVITY, THE INSPECTOR IS ALLOWED TO DOCUMENT COMPLETION OF INSPECTION STEPS, BASED ON OBJECTIVE EVIDENCE FROM THE COGIZANT SFR OR QE THAT THOSE STEPS HAVE BEEN COMPLETED AS DESCRIBED IN THE INSPECTION PLAN. ATTACH COPIES OF THE OBJECTIVE EVIDENCE TO THIS PLAN.

Final QE Review:

Date:

WO/SC/PO No. S00-021052	Requester: S Davies	Requester Approval: <i>TOM HIPPERMAN 12/26/02</i>	QE: Ron Staymales <i>RS</i>
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility Package Receipt Inspection Activities (CAS Control Enclosure)			Release Date: 12/26/02 - <i>12/26/02</i> <i>RS 12/26/02</i>

IP No. 21052-R-03		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
N/A	N/A	N/A	N/A	<p>Subcontractor material that is safety class (Q-1), safety significant (Q-2) or low safety consequence (Q-3) requires receipt inspection. This includes the following items, as a minimum: (see Form 414.02 & 414.70 for details)</p> <p>1) Inspector shall record the following information on the Inspection Report:</p> <p>A) Item description B) VDS item number, as applicable C) Quantity inspected D) Serial numbers/unique identifying numbers</p>	N/A
1.0	<p>CAS Control Enclosure</p> <p>(Warbonnet Electrical)</p> <p>REF. PLAN EP-18 R3 7/24/02</p>	TPR-8418	Visual / 100%	<p>Verify the following conditions, as applicable</p> <ol style="list-style-type: none"> 1) Damage 2) Cleanliness 3) protective coating 4) markings / identification 5) dimensional (random) - utilize approved fab drawings, catalogue cuts, etc. 6) surface condition / finish 7) weld appearance 8) end protection 9) end preparation 10) storage level & segregation per MCP-8438 (this is not an accept/reject attribute. If material is not being segregated, document on an IR and forward the IR to the QE) <p>IR number: 021052-E-096</p>	<p>WCSO</p> <p>3-4-03</p>
1.1	Per VDS	TPR-8418	Visual / 100%	<p>Verify that the material is traceable to the associated documentation, and that it complies with the approved vendor data.</p> <p>IR number: 021052-E-096</p>	<p>WCSO</p> <p>3-4-03</p>

CONSTRUCTION INSPECTION PLANNING PACKAGE

IP No. 21052-R-03		Rev. 0			
Item No.	Process/Item/Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.2	Per Form 431.53 For Drawing 522776, dated 12/18/02	MCP-3772 / TPR-8418	Verify / 100%	Perform inspections specified on the CGI Form 431.53, for the items identified with an * and attach to this plan. Document inspections on an IR Form 414.03. <i>Note SEE CHANGE Number #150 MS 3-4-03</i> Record IR numbers: 021052-E-096 <i>SEE 021052-E-095 RECEIPT INSPECTION ALSO P. 4463</i>	MSD 2.2 3-4-03
1.3	Per Form 414.02 and / or 414.70	TPR-8418	Verify / 100%	Apply a QC Accept tag to the items, where practical. When this is not feasible, the tag shall be placed with the inspection report for future reference. NOTE: All items accepted shall be uniquely identified to indicate acceptance. This identification shall consist of either placing a tag, where possible or by applying the QA number and initial/date physically on the item with a black indelible marker.	MSD 3-4-03
2.0	Inspection Plan	MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	MSD 3-4-03

INSPECTION PLAN GENERAL NOTES

- IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY, ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, UNE NUMBER, ROOM NUMBER ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 114.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- M & T SERIAL NUMBERS AND CALIBRATION W E DATES HAVE BEEN RECORDED.
- NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-598 / 598.
- ALL BLANKS HAVE BEEN COMPLETED OR WAD.
- WHEN PERFORMING LIQUID PENETRANT EXAMINATION RECORD THE BATCH NUMBER ON EITHER THE WELD HISTORY RECORD OR THE IR OR THE CIP.
- ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- VERIFY THAT APPUCABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.

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CONSTRUCTION INSPECTION PLANNING PACKAGE

- 13) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
- A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 14) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT ITEMS PER MCP-911U.
- 15) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY QUALIFIED PERSONNEL OTHER THAN A "GENERAL INSPECTOR".
- 16) WHEN CONFLICTS ARISE THAT PRECLUDE THE INSPECTOR FROM PERFORMING A VERIFICATION ACTIVITY, THE INSPECTOR IS ALLOWED TO DOCUMENT COMPLETION OF INSPECTION STEPS, BASED ON OBJECTIVE EVIDENCE FROM THE COGIZANT STR OR QE THAT THOSE STEPS HAVE BEEN COMPLETED AS DESCRIBED IN THE INSPECTION PLAN. ATTACH COPIES OF THE OBJECTIVE EVIDENCE TO THIS PLAN.

CONSTRUCTION INSPECTION PLANNING PACKAGE

Final OE Review:

Ray Staymales
8/16/03
Date: 1-24-03

WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: <i>Steve Davies</i>	Requester: Ron Staymales 10/21/02 <i>RS</i>
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility Installation Package			Release Date: 12/27/02

IP No. 21052-S-02		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria	Method/Procedure	Instructions	Complete Initial/Date
1.0	Structural	5060, pg 3 line 25 thru 36	Verify 100%	Verify that the welders are qualified to perform the welding process and have a current qualification. 021052-S-014 021052-S-137 Record IR number: 021052-S-014 021052-S-137	1-21-03
1.1	Structural	5060, pg 4 line 30 thru 37	Verify 100%	Verify that the filler metal is the correct type per the WPS and that it is traceable to an actual CMTR. 021052-S-137 Record IR number: 021052-S-014 021052-S-137	1-21-03
1.2	Structural	5060, pg 5 line 11 thru 44 & pg 6 line 1 thru 35	Verify 100%	Verify that the welding process is being performed in accordance with the parameters defined in the approved WPS, including the following: a) base metal preparation c) cleaning c) preheat temperature d) interpass temperature e) temporary welds f) backing strips/runoff tabs g) joint preparation Record IR number: 021052-S-137	1-21-03

CONSTRUCTION INSPECTION PLANNING PACKAGE

IP No. 21052-S-02		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.3	Structural Welding CRITICALITY DETECTOR CLUSTER FRAME	5060	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: 021052-S-137 021052-S-137	KB 1-21-03
1.4	Structural Welding CRITICALITY DETECTOR CLUSTER FRAME	5060	Verify 100%	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as 021052-S-137 KB 8-16-03 021052-S-137	KB 1-21-03
1.5	Structural Welding CRITICALITY DETECTOR CLUSTER FRAME	5060 and Approved Shop Drawings	TPR-4981, Appendix D Visual Random (20% minimum) Static Loaded HOLD POINT	Visually inspect welds per AWS D1.1 Record IR Number: 021052-S-137 021052-S-137 NOTE: In-house inspections shall be documented by the Steel Erector per the approved vendor data	KB 1-21-03
2.1	Structural Steel CRITICALITY DETECTOR CLUSTER FRAME	Approved Shop Drawings	Verify Random	Verify that the dimensions shown on the shop the shop drawings are in conformance with the shop drawings. Tolerances indicated Record IR number: 021052-S-137 KB 8-16-03 021052-S-137	KB 1-21-03
3.0	Structural Steel and Misc. Metal CRITICALITY DETECTOR CLUSTER FRAME	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: 021052-S-137	KB 1-21-03
4.0	General CRITICALITY DETECTOR CLUSTER FRAME	MCP-9436 App. A, B & C	Verify Random	Verify that materials / items are segregated based on quality level, with no comingling of quality levels. Record IR number: 021052-S-137 KB 8-16-03 021052-S-137	KB 1-21-03

CONSTRUCTION INSPECTION PLANNING PACKAGE

IP No. 21052-S-02		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
4.1	General CRITICALITY DETECTOR CLUSTER FRAME	MCP-9436 & STD-7006	Verify 100%	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: 021052-S-017 KB F-16-03 021052-S-137	KB 1-23-03
4.2	General CRITICALITY DETECTOR CLUSTER FRAME	MCP-9436	Verify 100%	Verify that the material is traceable to the approved documentation (CMTR's, P.O's, etc.) Record IR number: 021052-S-017 KB F-16-03 021052-S-137	KB 1-23-03
5.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	do

CONSTRUCTION INSPECTION PLANNING PACKAGE

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM **414.03**, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM **414.04** "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM **432.43**, **432.44** AND **432.45**)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
9. ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
10. ALL LINE OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
11. VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED AS APPLICABLE PRIOR TO PERFORMING INSPECTIONS.
12. INSTALLATION INSPECTIONS SHALL INCLUDE AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".

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CONSTRUCTION INSPEC: PLANNING PACKAGE

414.B1#
09/08/97
Rev. #01

Final QE Review:

Date:

Requester: Steve Davies	Requester Approval: <i>STEVE DAVIES RAE</i>	QE: Ron Staymales 10/21/02 <i>RF</i>	Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility Installation Package <i>02/01/1973/62</i>
WO/SC/PO No. 021052		Release Date: 10/22/02	

IP No. 21052-S-03		Rev. 0				
Item No.	Process/Item	Acceptance Criteria	Method/Procedure	Instructions	Complete Initial/Date	
	SHOP INSPECTIONS	Equipment Reference	Reference			
1.0	Structural Welding CRITICALITY	5060, pg 3 line 25 thru 36	Verify 100%	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: 021052-S-045	1-21-03	176
	FRAME HOUSING CONSOLE					
1.1	Structural Welding CRITICALITY	5060, pg 4 line 30 thru 37	Verify 100%	Verify that the filler metal is the correct type per the WPS and that it is traceable to an actual CMTR. Record IR number: 021052-S-046	1-21-03	176
	FRAME HOUSING CONSOLE					
1.2	Structural Welding CRITICALITY	5060, pg 5 line 11 thru 44 & pg 6 line 1 thru 35	Verify 100%	Verify that the welding process is being performed in accordance with the parameters defined in the approved WPS, including the following: a) base metal preparation b) cleaning c) preheat temperature d) interpass temperature e) temporary welds f) backing strips/runoff tabs g) joint preparation Record IR number: 021052-S-047	1-21-03	176
	FRAME HOUSING CONSOLE					

22-0357500 L.MIT

IP No. 21052-S-03		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.3	Structural Welding CRITICALITY CONSOLE HOUSING FRAME	5060	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: 021052-S-045	EB 1-21-03
1.4	Structural Welding CRITICALITY CONSOLE HOUSING FRAME	5060	Verify 100%	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 021052-S-045	EB 1-21-03
1.5	Structural Welding CRITICALITY CONSOLE HOUSING FRAME	5060 and Approved Shop Drawings	TPR-4981, Appendix D Visual Random (20% minimum) Static Loaded HOLD POINT	Visually inspect welds per AWS D1.1. Record IR Number: 021052-S-045 NOTE: In-house inspections shall be documented by the Steel West Inspector per the approved vendor data.	EB 1-21-03
2.0	Structural Steel CRITICALITY CONSOLE HOUSING FRAME	Approved Shop Drawings	Verify / Random	Verify that the dimensions shown on the shop the shop drawings are in conformance with the shop drawings and tolerances indicated. Record IR number: 021052-S-045	EB 1-21-03
3.0	Structural Steel and Misc. Metal CRITICALITY CONSOLE HOUSING FRAME	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: 021052-S-045	EB 1-21-03
4.0	General CRITICALITY CONSOLE HOUSING FRAME	MCP-9438 App. A, B & C	Verify Random	Verify that materials / items are segregated based on quality level, with no commingling of quality levels. Record IR number: 021052-S-045	EB 1-21-03

CONSTRUCTION INSPECT. PLANNING PACKAGE

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IP No. 21052-S-03		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
4.1	General CRITICALITY CONSOLE HOUSING FRAME	MCP-9436 & STD-7006	Verify 100%	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: 011 051-5-045	JS 1-21-03
4.2	General CRITICALITY CONSOLE HOUSING FRAME	MCP-9436	Verify 100%	Verify that the material is traceable to the approved documentation (CMTR's, P.O's, etc.) Record IR number: 031 051-5-045	JS 1-21-03
5.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	JS 1-23-03

CONSTRUCTION INSPECTION / PLANNING PACKAGE

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INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY R REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.461
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (I.E. BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A 'GENERAL INSPECTOR'.

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414.81#
09/08/97
Rev. #01

CONSTRUCTION INSPECTION PLANNING PACKAGE

Final QE Review: Ron Staymates Date: 1-24-03
8/16/03

WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: <u>Steve Davies</u>	QE: Ron Staymates 10/21/02
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility Package, Steel West Shop Inspection Light/Horn & Alarm Pole Supports			Release Date: <u>12/11/02</u>

P NO. 21052-S-04		Rev. 1	Rev. 1 added additional items for shop inspection		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
	SHOP INSPECTIONS			SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION.	
				ALL WELDING PROCESSES SHALL BE DOCUMENTED.	
1.0	Structural Welding	.060	Verify 100%	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: <u>021052-S-136</u> <u>KB 8-16-03</u>	<u>KB</u> <u>1-23-03</u>
1.1	Structural Welding	.060	Verify 100%	Verify that the filler metal is the correct type per the WPS and that it is traceable to an actual CMTR Record IR number: <u>021052-S-136</u> <u>KB 8-16-03</u>	<u>1-23-03</u>
1.2	Structural Welding LIGHT/HORN & ALARM POLE SUPPORTS	.060	Verify 100%	Verify that the welding process is being performed in accordance with the parameters defined in the approved WPS, including the following: a) base metal preparation b) cleaning c) preheat temperature d) interpass temperature e) temporary welds f) backing strips/runoff tabs g) joint preparation Record IR number: <u>021052-S-136</u> <u>KB 8-16-03</u>	<u>KB</u> <u>1-23-03</u>
1.3	Structural Welding LIGHT/HORN & ALARM POLE SUPPORTS		100%	single weld. Written approval is required to proceed with more than two repairs. Record IR number: <u>021052-S-136</u> <u>KB 8-16-03</u>	<u>KB</u> <u>1-23-03</u>

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CONSTRUCTION INSPECTION PLANNING PACKAGE

IP No. 21052-S-04		Rev. 1			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.4	Structural Welding LIGHT/HORN & ALARM POLE SUPPORTS	5060	Verify 100%	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. <i>021052-S-136</i> Record IR number: <i>021052-S-045 KB 8-16-03</i>	<i>KB</i> <i>1-23-03</i>
1.5	Structural Welding LIGHT/HORN & ALARM POLE SUPPORTS	5060 and Approved Shop Drawings S-10, 11 & 8	TPR-4981, Appendix D Visual Random (20% Minimum) Static Loaded HOLD POINT	Visually inspect welds per AWS D1.1 Record IR Number: <i>021052-S-045 KB 8-16-03</i> NOTE In-house inspections shall be documented by the Steel West Inspector per the approved vendor data.	<i>KB</i> <i>1-23-03</i>
2.0	Structural Steel LIGHT/HORN & ALARM POLE SUPPORTS	Approved Shop Drawings S-10, 11 & 8	Verify / Random	Verify that the dimensions shown on the shop the shop drawings are in conformance with the shop drawings and tolerances indicated Record IR number: <i>021052-S-045 KB 8-16-03</i> <i>021052-S-136</i>	<i>KB</i> <i>1-23-03</i>
2.1	Structural Steel and Misc. Metal LIGHT/HORN & ALARM POLE SUPPORTS	Approved Shop Drawings S-3 and S-11 (See AE drawings 522664 & 522665 for additional information)	Verify 100%	Perform inspections specified on the CGI Form 431 53 for the items identified below and attach to this plan. Document inspections on an IR Form 414 03 1) 3-1/2 inch sch. 40 bulk pipe 2) 1/2 inch sch. 40 pipe nipple — <i>1/2" x 1-1/4"</i> 3) self tapping screws — <i>1/4" x 3/4"</i> 4) socket head cap screws <i>1/4" x 3/4"</i> 5) split ring lock washers 6) 3/4 x 3-1/2 inch grade 8 bolts 7) 1 3/4 inch grade 8 nuts Record IR number: <i>021052-S-045 KB 8-16-03</i>	NA See Inspection Plan 21052-R-02 <i>KB 8/19/03</i> <i>1-23-03 KB</i>
3.0	Structural Steel and Misc. Metal LIGHT/HORN & ALARM POLE SUPPORTS	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: <i>021052-S-045 KB 8-16-03</i> <i>021052-S-136</i>	<i>KB</i> <i>1-23-03</i>
4.0	General LIGHT/HORN & ALARM POLE SUPPORTS	MCP-9436 App. A, B & C	Verify Random	Verify that materials / items are segregated based on quality level, with no commingling of quality levels. Record IR number: <i>021052-S-045 KB 8-16-03</i> <i>021052-S-136</i>	<i>KB</i> <i>1-23-03</i>

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CONSTRUCTION INSPECTION PLANNING PACKAGE

IP No. 21052-S-04		Rev. 1	Rev. 1 added additional items for shop inspection		
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
4.1	General LIGHT/HORN & ALARM POLE SUPPORTS	MCP-9436 & STD-7006	Verify 100%	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: 021052-S-045 021052-S-136 16 P-16-03	16 1-23-03
4.2	General LIGHT/HORN & ALARM POLE SUPPORTS	MCP-9436	Verify 100%	Verify that the material is traceable to the approved documentation (CMTR's, P.O's, etc.) Record IR number: 021052-S-045 021052-S-136 16 P-16-03	16 1-23-03
5.0	General	MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	16 1-23-03

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION/ ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538/ 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION

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CONSTRUCTION INSPECTION PLANNING PACKAGE

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- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".

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CONSTRUCTION INSPECTOR LANNING PACKAGE

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Final QE Review:

Date: 1-24-03

WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: STEVE DAVIES PER	QE: Ron Staymates 10/21/02 Rf
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility Installation Package			Release Date: 10/23/02

IP No. 21052-5-05		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
	SHOP INSPECTIONS			SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL WELDING	
1.0	Structural Welding CRITICALITY ALARM SUPPORTS	5060, pg 3 line 25 thru 36	Verify 100%	Verify that the welders are qualified to perform the TIG process and have a current qualification. Record IR number: 021052-8-045	RB 1-21-03
1.1	Structural Welding CRITICALITY ALARM SUPPORTS	5060, pg 4 line 30 thru 37	Verify 100%	Verify that the filler metal is the correct type per the WPS and that it is traceable to an actual CMTR. Record IR number: 021052-8-045	RB 1-21-03
1.2	Structural Welding CRITICALITY ALARM SUPPORTS	5060, pg 5 line 11 thru 44 & pg 6 line 1 thru 35	Verify 100%	Verify that the welding process is being performed in accordance with the parameters defined in the approved WPS, including the following: a) base metal preparation b) cleaning c) preheat temperature d) interpass temperature e) temporary welds f) backing strips/runoff tabs g) joint preparation Record IR number: 021052-8-045	RB 1-21-03
1.3	Structural Welding CRITICALITY ALARM SUPPORTS	5060, pg 6 line 37 thru 42 & pg 7 line 1 thru 12	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: 021052-8-045	RB 1-21-03

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CONSTRUCTION INSPECTION PLANNING PACKAGE

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IP No. 21062-S-05		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.4	Structural Welding CRITICALITY ALARM SUPPORTS	5060	Verify 100%	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 021062-S-045	LB 1-24-03
1.5	Structural Welding CRITICALITY ALARM SUPPORTS	5060 and Approved Shop Drawings	TPR-4981, Appendix D Visual Random (20% Minimum) Static Loaded HOLD POINT	Visually inspect welds per AWS D1.1. Record IR Number: 021062-S-045 NOTE: In-house inspections shall be documented by the Steel West Inspector per the approved vendor data.	LB 1-21-03
2.0	Structural Steel CRITICALITY ALARM SUPPORTS	Approved Shop Drawings	Verify / Random	Verify that the dimensions shown on the shop the shop drawings are in conformance with the shop drawings and tolerances indicated. Record IR number: 021062-S-045	LB 1-21-03
3.0	Structural Steel and Misc. Metal CRITICALITY ALARM SUPPORTS	MCP-8110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: 021062-S-045	LB 1-21-03
4.0	General CRITICALITY ALARM SUPPORTS	MCP-9436 App. A, B & C	Verify Random	Verify that materials / items are segregated based on quality level, with no commingling of quality levels. Record IR number: 021062-S-045	LB 1-21-03
4.1	General CRITICALITY ALARM SUPPORTS	MCP-9436 & STD-7006	Verify 100%	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: 021062-S-045	LB 1-21-03
4.2	General CRITICALITY ALARM SUPPORTS	MCP-9436	Verify 100%	Verify that the material is traceable to the approved documentation (CMTR's, P.O's, etc.) Record IR number: 021062-S-045	LB 1-21-03
5.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	LB 1-23-03

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INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION [HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.] TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-638 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR NIA'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC; ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".

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Final QE Review:

Date: 12-16-02

WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: STEVE DAVIES PER	QE: Ron Staymates 10/31/02
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (DCN FS-19)			KAREN SHARPSTARE 11/4/02
Floor Structure is safety significant (Q2) / RCS is safety significant (Q2)			Release Date: 11-4-02

PNo. 21052-S-06		Rev. 0			
No.	Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL WELDING PROCESSES TO THE FLOOR STRUCTURE SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS.	N/A
1.0	Structural Welding Per DCN FS-19	5060	Verify 100%	Verify that the welders are qualified to perform the welding process and have a current qualification and has been approved in the vendor data system. Record IR number: 021052-S-029	12-12-02 CEK
1.1	Structural Welding Per DCN FS-19	5060	Verify random	Verify that the filler metal is the correct type per the WPS and that it is traceable to a CMTR and has been approved in the vendor data system. Record IR number: 021052-S-029	12-12-02 CEK
1.2	Structural Welding Per DCN FS- 9	5060	Verify random	Verify that the welding process is being performed in accordance with the parameters defined in the approved vendor data WPS, including the following: a) base metal preparation 12-12-02 CEK b) cleaning 12-12-02 CEK c) preheat temperature 12-12-02 CEK d) interpass temperature 12-12-02 CEK e) temporary welds 12-12-02 CEK f) backing strips/runoff tabs 12-12-02 CEK g) joint preparation 12-12-02 CEK Record IR number: 021052-S-029	12-12-02 CEK
1.3	Structural Welding Per DCN FS-19	060	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: 021052-S-029	12-12-02 CEK
1.4	Structural Welding Per DCN FS-19	060	Verify random	Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified. Record IR number: 021052-S-029	12-12-02 CEK

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IP No. 21052-S-08		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.5	Structural Welding Per DCN FS-19	5060	TPR-496, Appendix D Visual 100% Static Loaded HOLD POINT	Visually inspect pipe sleeve welds per AWS D1.1. Record IR Number: <i>See IP 021052-S-01</i>	<i>N/A</i>
2.0	General	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: <i>021052-S-029</i>	<i>12-12-02</i> <i>CER</i>
3.0	General	MCP-9436 App. A, B & C	Verify Random	Verify that materials / items are segregated based on quality level, with no commingling of quality levels. Record IR number: <i>021052-S-029</i>	<i>12-12-02</i> <i>CER</i>
4.0	General	MCP-9436 App. A, B & C And STD-7006	Verify Random	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: <i>021052-S-029</i>	<i>12-12-02</i> <i>CER</i>
5.00	General	MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QC for closure. <i>021052-S-029</i>	<i>12-12-02</i> <i>CER</i>

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS,
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QC FOR RESOLUTION
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION/ ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS);
- 7) MATERIAL SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-638 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.

12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:

- A) ANCHOR BOLT PLACEMENT
- B) ANCHOR BOLT TORQUE
- C) LOCATION
- D) ELEVATION
- E) ORIENTATION

13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.

14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION. (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A 'GENERAL INSPECTOR'.

15) CHECKLIST 414.A15 IS BEING PILOTTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE.

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CONSTRUCTION INSPECTION PLANNING PACKAGE

Final QE Review: *Ron Staymates* Date: 4-28-03

WO/SC/PO No. 021052	(Requester: Steve Davies)	Requester Approval: <u>STEVE DAVIES P.M. EMAIL</u>	QE: Ron Staymates 10/25/02 <u>FB</u>
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility Package, Atlas Shop Inspection <u>11/6/02</u>			Release Date: <u>11-6-02</u>

P No. 21052-V-01		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
	SHOP INSPECTIONS			SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION.	
				ALL WELDING PROCESSES SHALL BE DOCUMENTED.	
1.0	Structural Welding STAINLESS STEEL DUCTWORK	15014	Verify 100%	Verify that the welders are qualified to perform the welding process and have a current qualification. Record IR number: <u>021052-V-042</u>	<u>RB</u> 8-16-03 <u>11-6-02</u>
1.1	Structural Welding STAINLESS STEEL	15014	Verify 100%	Verify that the filler metal is the correct type per the WPS and that it is traceable to an actual CMTR Record IR number: <u>021052-H-044 11-15-03</u>	<u>RB</u> 8-16-03 <u>11-6-02</u>
1.2	Structural Welding STAINLESS STEEL DUCTWORK	5014	Verify 00%	Verify that the welding process is being performed in accordance with the parameters defined in the approved WPS, including the following: a) base metal preparation b) cleaning c) preheat temperature d) interpass temperature e) temporary welds f) backing strip/shutoff tabs g) joint preparation Record IR number: <u>021052-V-042 11-15-03</u>	<u>RB</u> 2-24-03
1.3	Structural Welding STAINLESS STEEL DUCTWORK	15014	Verify 00%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: <u>021052-V-098</u>	<u>RB</u> 2-24-03

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CONSTRUCTION INSPECTION PLANNING PACKAGE

IP No. 21052-V-01		Rev. 0	
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria	Reference
1.4	Structural Welding STEEL DUCTWORK	15014	Verify 100%
1.5	Structural Welding STEEL DUCTWORK	15014	Verify Random
1.6	Structural Welding STEEL DUCTWORK	15014 and Approved Shop Drawings	TPR-4981 Visual 100% Static Loaded HOLD POINT
1.7	Structural Welding STEEL DUCTWORK	15014	TPR-4975, Appendix C Visual 100%
2.0	Structural Steel STEEL DUCTWORK	Approved Shop Drawings	Verify Random
3.0	Structural Steel and Misc. Metal STEEL DUCTWORK	MCP-9110	Verify Random
4.0	General STEEL DUCTWORK	MCP-9436 App. A, B & C	Verify Random
4.1	General STEEL DUCTWORK	MCP-9436 & STD-7006	Verify 100%
<p>Verify that arc strikes have been ground to a smooth contour but no more than 1/32 in. of base metal shall be removed. Arc strikes exceeding more than 1/32 in. into the base metal shall be considered as a weld defect and repaired as specified.</p> <p>Record IR number: 021052-H-014.50</p> <p>Verify that any temporary welds utilized during the fabrication process have been removed and the base metal ground smooth and flush.</p> <p>Record IR number: 021052-H-003</p> <p>17.10.4.103</p>			
<p>Visually inspect welds per AWS D9.1 (copy attached).</p> <p>NOTE: Welder identification and Weld identification are required to be vibro-etched adjacent to the weld</p> <p>Record IR Number: 021052-H-015</p> <p>17.10.4.103</p> <p>This was deleted to acc to 15014 & 15014.50</p> <p>17.10.4.103</p>			
<p>Liquid Penetrant examine the final pass on all welds, using water washable design change document (DCN / FCR).</p> <p>Record IR number: 021052-H-014.50</p>			
<p>Verify that the dimensions shown on the shop drawings are in conformance with the shop drawings and tolerances indicated.</p> <p>Record IR number: 021052-H-042</p> <p>021052-H-34</p>			
<p>Verify that no suspect / counterfeit items have been utilized.</p> <p>Record IR number: 021052-H-30</p>			
<p>Verify that materials / items are segregated based on quality level, with no commingling of quality levels.</p> <p>Record IR number: 021052-H-30</p>			
<p>Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) 21052-H-13</p> <p>Record IR number: 021052-H-30</p>			

Approved by STEVE DAVIES per TELETYPE 12/2/03

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IP No. 21052-V-01		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
4.2	General STAINLESS STEEL DUCTWORK	MCP-9436	Verify 100%	Verify that the material is traceable to the approved documentation (CMTR's, P.O's, etc.) Record IR number: 021052-N-010 N-011	2.0 1-13-03
5.0		MCP-2432	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	2.0 2-24-03

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE OEM FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS [FORM 432.43, 432.44 AND 432.45]
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & T SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WHITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION. (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A 'GENERAL INSPECTOR'.

22-0358162 LMIT

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CONSTRUCTION INSPECTION PLANNING PACKAGE

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Final QE Review:

Date:

WO/SO/PO No. 021052	Requester: Steve Davies	Requester Approval: <i>SLOTT JENSEN PER EMAIL</i>	QE: Ron Staymates 12/16/02 <i>PK</i>
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (ICR-006 Rework Activities) Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2) <i>12/16/02</i>			Release Date: 12-16-02

IP No. 21052-M-07		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				<p>SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION.</p> <p>ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS.</p> <p>THESE STEPS MAY BE WORKED IN ANY SEQUENCE NECESSARY TO COMPLETE THE WORK ACTIVITIES</p>	
1.0	RCS Panel WP-02	ICR-065 (COPY ATTACHED)	Verify Random	Verify that the panel has been reworked in accordance with the ICR.	3-6-03 CFR
1.1	RCS Panel WP-02	ICR-065	Verify Random	Verify that the rivets are installed per the ICR.	3-6-03 CFR
1.2	RCS Panel WP-02	ICR-065	Verify Random	Verify that the caulking has been installed per the ICR.	3-6-03 CFR
2.0	RCS Panel WP-106	ICR-065	Verify Random	Verify that the panel has been reworked in accordance with the ICR.	3-6-03 CFR
2.1	RCS Panel WP-106 NVP-106	ICR-065	Verify 100%	Verify that the rivets are installed per the ICR.	3-6-03 CFR
2.2	RCS Panel WP-106	ICR-065	Verify Random	Verify that the caulking has been installed per the ICR.	3-6-03 CFR
3.0	RCS Panel WP-100	ICR-065	Verify Random	Verify that the panel has been reworked in accordance with the ICR.	1-16-03 CFR

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IP No. 21052-M-07		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
3.1	RCS Panel WP-100	ICR-065	Verify Random	Verify that the rivets are installed per the ICR.	1-16-93 CEL
3.2	RCS Panel WP-100	ICR-065	Verify Random	Verify that the caulking has been installed per the ICR.	1-16-93 CEL
2.0	RCS	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IP number N-A CEL	1-16-93 CEL
3.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	1-16-93 CEL

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS WILL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR 03 NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: RATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCF / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - R) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION

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- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-0110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".
- 15) CHECKLIST 414.A15 IS BEING PILOTTED IN THIS INSPECTION PLAN (REF. TPR-4921), AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE.

22-0358110 LMIT

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CONSTRUCTION INSPECTION LANNING PACKAGE

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Final QE Review:

Date: 1/29/03

WO/SC/PO No. 021D52	Requester: Steve Davies	Requester Approval: <i>Scott Jensen for DMAC</i>	QE: Ron Staymates 11/11/02 <i>PS</i>
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (ICR-062 REWORK ACTIVITIES)			
Floor Structure is safety significant (Q2) / WES is low safety significant (Q3) / RCS is safety significant (Q2)			
			Release Date: 12-5-02

IP No. 21052-M-06		Rev. 0			
Item No.	Process/Item: Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS. THESE STEPS MAY BE WORKED IN ANY SEQUENCE NECESSARY TO COMPLETE THE WORK ACTIVITIES	
1.0	RCS Pane WP-23	ICR-062	Verify Random	Verify that the silicone caulk is removed per step 1. <i>IR 02-1052-S-043</i>	1-15-03 <i>CEK</i>
1.1	RCS Pane WP-23	ICR-062	Verify Random	Verify that the rivets are removed per step 2. <i>IR 02-1052-S-043</i>	1-15-03 <i>CEK</i>
1.2	RCS Pane WP-23	ICR-062	Verify Random	Verify that the sheathing is removed per step 3. <i>IR 02-1052-S-043</i>	1-15-03 <i>CEK</i>
1.3	RCS Panel WP-23	ICR-062	Verify Random	Verify that the remaining caulk is removed per step 4. <i>IR 02-1052-S-043</i>	1-15-03 <i>CEK</i>
1.4	RCS Panel WP-23	ICR-062	Verify 100%	Verify that the sheet is rotated 180 degrees per step 5. <i>IR 02-1052-S-043</i>	1-15-03 <i>CEK</i>
1.5	RCS Panel WP-23	ICR-062	Verify Random	Verify that the sheet is shimmed per step 6. <i>IR 02-1052-S-043</i>	1-15-03 <i>CEK</i>
1.6	RCS Panel WP-23	ICR-062	Verify Random	Verify that the sheet is centered per step 7. <i>IR 02-1052-S-043</i>	1-15-03 <i>CEK</i>

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CONSTRUCTION INSPECTION PLANNING PACKAGE

P No. 21052-M-06		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.7	RCS Panel WP-23	ICR-062	Verify Random	Verify that the holes are drilled per step 8. <i>IR 021052-S-043</i>	<i>1-15-03</i> <i>CER</i>
1.8	RCS Panel WP-23	ICR-062	Verify Random	Verify that the sheet is caulked per step 9. <i>IR 021052-S-043</i>	<i>1-15-03</i> <i>CER</i>
✓ 1.9	RCS Panel WP-23	ICR-062	Verify 100%	Verify that the rivets are installed per step 10. <i>IR 021052-S-043</i>	<i>1-15-03</i> <i>CER</i>
1.10	RCS Panel WP-23	ICR-062	Verify Random	Verify that the holes are drilled out per step 11. <i>IR 021052-S-043</i>	<i>1-15-03</i> <i>CER</i>
✓ 1.11	RCS Panel WP-23	ICR-062	Verify 100%	Verify that the rivets are installed per step 12. <i>IR 021052-S-043</i>	<i>1-15-03</i> <i>CER</i>
1.12	RCS Panel WP-23	ICR-062	Verify 100%	Verify that the sheet is caulked per step 13. <i>IR 021052-S-043</i>	<i>1-15-03</i> <i>CER</i>
✓ 2.0	RCS	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: <i>021052-S-043</i>	<i>1-15-03</i> <i>CER</i>
✓ 3.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure. <i>021052-S-043</i>	<i>1-15-03</i> <i>CER</i>

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS WILL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).

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CONSTRUCTION INSPECTION PLANNING PACKAGE

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- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BUNKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC., MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR"
- 15) CHECKLIST 414.A15 IS BEING PILOTTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE.

CONSTRUCTION INSPECTIC LANNING PACKAGE

Final QE Review:

Date:

WO/SC/PO No. C21052	Requester: Steve Davies	Requester Approval: KAREN SHROPSHIRE PER 6/11/02	QE: Ron Staymates 12/19/02
Activity/Project Description: CU 7-10 Glovebox Excavator Method Facility (ICR-041 REWORK ACTIVITIES)			Release Date: 12-19-02
Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2)			

IP No. 21052-M-00		Rev. 0			
	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES P A M FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS. THESE STEPS MAY BE WORKED IN ANY SEQUENCE NECESSARY TO COMPLETE THE WORK ACTIVITIES	
1.0	WES	ICR-041 (COPY ATTACHED)	Verify Random	Verify that the snow shields and penetrations have been installed per the ICR, item 1.	2-6-03 CEK
1.1	WES	ICR-041	Verify Random	Verify that the door sweeps have been installed per the ICR, item 2.	2-6-03 CEK
1.2	WES	ICR-041	Verify Random	Verify that the pressure plates have been installed per the ICR, item 3.	2-6-03 CEK
2.0	WES	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: 021052-5-045	2-6-03 CEK
3.0		MCP-2492	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	2-6-03 CEK

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.

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CONSTRUCTION INSPECTION PLANNING PACKAGE

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- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION/ ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / OR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BUNKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".
- 15) CHECKLIST 414.A15 IS BEING PILOTED IN THIS INSPECTION PLAN (REF-TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE.

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CONSTRUCTION INSPECTION PLANNING PACKAGE

Final QE Review:

Date:

4-9-03

WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: <i>KAREN SHOFER PERCHER</i>	QE: Ron Staymates 12/19/02
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (DCN FP-17)			Release Date: 12-19-02
Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2)			

P No. 21052-S-09		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION.	
				ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS.	
1.0	Stud Welds	DCN FP-17 and AWS C5.4 (copy attached)	Verify 100%	Verify that the mechanical test specified in section 9 is performed and acceptable prior to each initiation of production welding. Record IR number: 021052-S-093	3-4-03 CEK
1.1	Stud Welds	DCN FP-17 and AWS C5.4 (copy attached)	Verify 100%	Verify that the requirements of AWS C5.4, section 6 are being complied with, including base metal prep, equipment setup, etc. Record IR number: 021052-S-093	3-4-03 CEK
1.2	Stud Welds	DCN FP-17 and AWS C5.4 (copy attached)	Verify 100%	Verify that the requirements of AWS C5.4, section 8 are being complied with, including locating, perpendicularity, accessories, etc. Record IR number: 021052-S-093	3-4-03 CEK
1.3	Stud Welds	DCN FP-17 and AWS C5.4 (copy attached)	TPR-4981 Visual 100% Static Loaded HOLD POINT	Visually inspect welds per AWS C5.4, section 9. Record IR Number: 021052-S-093	3-4-03 CEK
2.0	Structural Steel and Misc. Metal	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: 021052-S-093	3-4-03 CEK
3.0	General	MCP-9433 App. A, B & C	Verify Random Checklist 414.A33	Verify that materials / items are segregated based on quality level, with no commingling of quality levels. Record IR number: 021052-S-093	3-4-03 CEK
3.1	General	MCP-9433 App. A, B & C And STD-7003	Verify Random Checklist 4: 4.A33	Verify that traceability markings (part numbers, heat numbers, etc.) are transferred when material is subdivided. (transfer can be by marking, tagging or other unique identifier) Record IR number: 021052-S-093	3-4-03 CEK

Nelson Steels and Equipment was utilized 3-4-03 CEK

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IP No. 21052-S-09		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
4.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	3-4-03 CER

INSPECTOR'S INITIALS AND NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) WCF / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-CUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".
- 15) CHECKLIST 414.015 IS BEING PILOTTED IN THIS INSPECTION PLAN (REF. TPR-4921). AND SUBJECT TO CLARIFICATION / REVISION DURING THE CONSTRUCTION ACTIVITIES WITH THE APPROVAL OF THE QE AND THE RE.

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CONSTRUCTION INSPECTION PLANNING PACKAGE

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Final QE Review:

Date: 4-9-03

WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: STEVE DAVIES FOR EMAIL	QE: Ron Staynates 10/03/02
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility Structures (FCR 13233-90).			Release Date: 1/27/03
Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2)			

IP NO. 21052-M-10		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NMLS PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION. ALL WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 432.45 OR FORM 432.43 OR THE DRAWINGS.	
1.0	Stainless Structural Steel (ref: Spec. 5060 criteria listed above)	5060	Verify random	Verify that the welders are qualified to perform the welding process and have a current qualification.	2-5-03 CER
1.1	Stainless Structural Steel (ref: Spec. 5060 criteria listed above)	5060	Verify random	Verify that the filler metal is the correct type per the WPS and that it is traceable to an actual CMTR with heat number. Record IR number: 021052-S-042	2-5-03 CER
1.2	Stainless Structural Steel (ref: Spec. 5060 criteria listed above)	5060	Verify random	Verify that the welding process is being performed in accordance with the parameters defined in the WPS (S-3.16 stainless or CS-3.04 carbon to stainless), including the following: a) base metal preparation 2-5-03 CER b) cleaning 2-5-03 CER c) preheat temperature 2-5-03 CER d) interpass temperature 2-5-03 CER e) temporary welds 2-5-03 CER f) backing strips/runoff tabs N/A g) joint preparation 2-5-03 CER Record IR number: 021052-S-042	2-5-03 CER

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CONSTRUCTION INSPECTION PLANNING PACKAGE

021052-S-042

IP NO. 21052-M-10		Rev. 0			
Item NO.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.3	Stainless Structural Steel (ref: Spec. 5060 criteria listed above)	5060	Verify 100%	Verify that any weld repairs are limited to a maximum of 2 (two) repairs on any single weld. Written approval is required to proceed with more than two repairs. Record IR number: 021052-S-042	2-5-03 CEK
1.4	Stainless Structural Steel (ref: Spec. 5060 criteria listed above)	5060	Verify Random	that strikes have been ground to a but no more than 1/32 in. of base metal shall be removed. Arc strikes less than 1/32 in. into the base metal shall be considered a weld defect and repairs as specified. Record IR number: 021052-S-042	2-5-03 CEK
1.5	Stainless Structural Steel (ref: Spec. 5060 criteria listed above)	5060	Visual 100% MOLD POINT Static Loaded	Visually inspect welds per AWS D1.6 utilizing II ed criteria section 6.26 (St Load d. Record IR Number: 021052-S-042	2-5-03 CEK
1.8	Stainless Structural Steel	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: 021052-S-042	2-5-03 CEK
2.0	General	MCP-9436 App. A, B & C	Verify Random Checklist 414.A33	Verify that materials/ items are segregated based on quality level, with no commingling of quality levels. Record IR number: 021052-S-042	2-5-03 CEK
2.1	General	MCP-9436 App. A, B & C And STD-7006	Verify Random Checklist 414.A33	Verify that traceability markings (QA numbers, heat numbers, etc.) are transferred when material is subdivided, (transfer can be by marking, tagging or other unique identifier). Record IR number: 021052-S-042	2-5-03 CEK
3.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure. 021052-S-042	2-5-03 CEK

INSPECTION PLAN GENERAL NOTES

- IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.

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- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION / ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BUNKS HAVE BEEN COMPLETED OR N/A'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM, THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-9110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".
- 15) WHEN CONFLICTS ARISE THAT PRECLUDE THE INSPECTOR FROM PERFORMING A VERIFICATION ACTIVITY, THE INSPECTOR IS ALLOWED TO DOCUMENT COMPLETION OF INSPECTION STEPS, BASED ON OBJECTIVE EVIDENCE FROM THE COGIZANT STR OR QE THAT THOSE STEPS HAVE BEEN COMPLETED AS DESCRIBED IN THE INSPECTION PLAN. ATTACH COPIES OF THE OBJECTIVE EVIDENCE TO THIS PLAN.

CONSTRUCTION INSPECTION PLANNING PACKAGE

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Final QE Review:

Roy Hayman

Date:

3/5/03

WO/SC/PO No. 021052	Requester: Steve Davies	Requester Approval: <i>STEVE DAVIES PER TELEPHONE</i>	QE: Ron Staymales 2/17/03
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility (GLOVEBOX LEAK TESTING ACTIVITIES)			<i>3/4/03</i>
Floor Structure is safety significant (Q2) / WES is low safety consequence (Q3) / RCS is safety significant (Q2)			Release Date: <i>2-18-03</i>

IP No. 21052-M-11		Rev. 0			
Item	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
				SEE ATTACHED GENERAL NOTES PAGE FOR ADDITIONAL INFORMATION RELATIVE TO THIS INSPECTION.	
				ALL SAFETY SIGNIFICANT AND LOW SAFETY CONSEQUENCE WELDING PROCESSES SHALL BE DOCUMENTED ON FORMS 432.44 AND 43245 OR FORM 432.43 OR THE DRAWINGS.	
1.0	Glovebox Number 1	IPP 21052-M-03	Verify 100%	Verify that all inspections on 21052-M-03 have been completed for Glovebox number 1.	N/A installation still in-process
2.0	Glovebox Number 2	IPP 21052-M-03	Verify 100%	Verify that all inspections on 21052-M-03 have been completed for Glovebox number 2.	N/A installation still in-process
3.0	Glovebox Number 3	IPP 21052-M-03	Verify 130%	Verify that all inspections on 21052-M-03 have been completed for Glovebox number 3.	N/A installation still in-process
4.0	Glovebox Number 1	Approved Test Procedure	Verify 100%	Verify that the glovebox, including windows and gloveports is Leak Tested in accordance with the manufacturers instructions. Record IR number: <i>021052-M-091</i>	<i>2-26-03</i> <i>CEK</i>
5.0	Glovebox Number 2	Approved Test Procedure	Verify 100%	Verify that the glovebox, including windows and gloveports is Leak Tested in accordance with the manufacturers instructions. Record IR number: <i>021052-M-091</i>	<i>2-26-03</i> <i>CEK</i>
6.0	Glovebox Number 3	Approved Test Procedure	Verify 100%	Verify that the glovebox, including windows and gloveports is Leak Tested in accordance with the manufacturers instructions. Record IR number: <i>021052-M-091</i>	<i>2-26-03</i> <i>CEK</i>
7.0	General	MCP-9110	Verify Random	Verify that no suspect / counterfeit items have been utilized. Record IR number: <i>021052-M-091</i>	<i>2-26-03</i> <i>CEK</i>
8.0		MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	<i>2-26-03</i> <i>CEK</i>

INSPECTION PLAN GENERAL NOTES

CONSTRUCTION INSPECTION PLANNING PACKAGE

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGE DOCUMENTS UTILIZED FOR INSPECTION ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M & TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BUNKS HAVE BEEN COMPLETED OR NIA'D.
- 10) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 11) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 12) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 13) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT PARTS OR COMPONENTS PER MCP-8110.
- 14) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY PERSONNEL QUALIFIED AS A "GENERAL INSPECTOR".

Final QE Review:

Date:

3/5/23

WO/SC/PO No. 500-021052	Requester: S Davies	Requester Approval: <i>TOM HOPPER</i> <i>24/03/03</i>	QE: Ron Staymates <i>FL</i>
Activity/Project Description: OU 7-10 Glovebox Excavator Method Facility Package Receipt Inspection Activities (Misc. CAS Electrical Items)			Release Date: 2/5/2003

Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
N/A	N/A	N/A	N/A	subcontractor material that is safety class (Q-1), safety significant (Q-2) or low safety consequence (Q-3) requires receipt inspection. This includes the following items, as a minimum: (see Form 414.02 & 414.70 for details) 1) Inspector shall record the following information on the Inspection Report: A) Item description B) VDS item number, as applicable C) Quantity inspected D) Serial numbers/unique Identifying numbers	N/A
1.0	Misc. CAS Electrical Rems Warbonnet, Electrical) 3EF FCR-13233-f 18 AND 13233-96	PR-6416	Visual / 100%	Verify the following conditions, as applicable 1) Damage 2) Cleanliness 3) protective coating 4) markings / identification 5) dimensional (random) – utilize approved fab drawings, catalogue cuts, etc. 6) surface condition / finish 7) weld appearance 8) end protection 9) end preparation 10) storage level & segregation per MCP-9436 (this is not an accept/reject attribute. If material is not being segregated, document on an IR and forward the IR to the QE) IR number. 021052-2-087	7M 2/18/03
1.1	per VDS	PR-6416	Visual/ 100%	Verify that the material is traceable to the associated documentation, and that it complies with the approved vendor data. IR number: 021052-5-057	7M 2/18/03

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IP No. 21052-R-03 <i>04</i>		Rev. 0			
Item No.	Process/Item/ Material or Equipment	Acceptance Criteria Reference	Method/Procedure Reference	Instructions	Complete Initial/Date
1.2	For Form 431.53 For Drawing 522770, dated 2/4/2003 and for Drawing 522777, dated 2/3/2003	MCP-3772 / TPR-8416	Verify / 100%	Perform inspections specified on the CGI Forms 431.53, for the items identified on the CGI forms. Document inspections on an IR Form 414.03. Record IR numbers: <i>621052-8-087</i>	<i>ml</i> <i>2/18/03</i>
1.3	Per Form 414.02 and / or 414.70	TPR-8416	Verify / 100%	Apply a QC Accept tag to the items, where practical. When this is not feasible, the tag shall be placed with the inspection report for future reference. NOTE: All items accepted shall be uniquely identified to indicate acceptance. This identification shall consist of either placing a tag, where possible or by applying the QA number and initial/date physically on the item with a black indelible marker.	<i>ml</i> <i>2/18/03</i>
2.0	Inspection Plan	MCP-2482	Verify	Verify that all inspections have been completed and forward this inspection plan to the QE for closure.	<i>ml</i> <i>2/4/03</i>

INSPECTION PLAN GENERAL NOTES

- 1) IF ANY ATTRIBUTE IS FOUND TO BE UNSATISFACTORY ON THE CIP, THEN ADDITIONAL INSPECTIONS SHALL BE PERFORMED UNTIL REASONABLE ASSURANCE IS ACHIEVED TO CONFIRM COMPLIANCE WITH THE INSPECTION PLAN REQUIREMENTS.
- 2) ALL INSPECTIONS, EXCEPT WELDING SHALL BE DOCUMENTED ON FORM 414.03, "QUALITY INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP. INSPECTION REPORTS SHALL BE COMPLETED AT LEAST DAILY. ANY IR REQUIRING ACTION SHALL BE FORWARDED TO THE QE FOR RESOLUTION.
- 3) WELDING INSPECTIONS SHALL BE DOCUMENTED ON FORM 414.04 "VISUAL INSPECTION REPORT" AND ATTACHED TO THE APPLICABLE CIP OR ON THE WELD HISTORY RECORDS (FORM 432.43, 432.44 AND 432.45)
- 4) WHEN DOCUMENTING INSPECTIONS, INCLUDE LOCATIONS OR OTHER IDENTIFICATION INFORMATION (HEAT NUMBER, LINE NUMBER, ROOM NUMBER, ETC.) TO PROVIDE TRACEABILITY TO THE ITEM.
- 5) ANY DESIGN CHANGED DOCUMENTS UTILIZED FOR INSPECTION [ACCEPTANCE SHALL ALSO BE DOCUMENTED ON FORM 414.03 OR NOTED ON THE APPLICABLE CIP ATTRIBUTE.
- 6) ATTACH A COPY OF ANY ASSOCIATED DOCUMENTS THAT WILL PROVIDE TRACEABILITY OR CLARIFICATION OF INSPECTIONS PERFORMED (IE: BATCH TICKETS).
- 7) M6 TE SERIAL NUMBERS AND CALIBRATION DUE DATES HAVE BEEN RECORDED.
- 8) NCR / DR INFORMATION HAS BEEN RECORDED PER MCP-538 / 598.
- 9) ALL BLANKS HAVE BEEN COMPLETED OR N/A'D.
- 10) WHEN PERFORMING LIQUID PENETRANT EXAMINATION RECORD THE BATCH NUMBERS ON EITHER THE WELD HISTORY RECORD OR THE IR

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- 11) ALL LINE-OUTS OR WRITE OVERS HAVE BEEN INITIALED AND DATED.
- 12) VERIFY THAT APPLICABLE VDS DOCUMENTS HAVE BEEN APPROVED OR SUBMITTED, AS APPLICABLE, PRIOR TO PERFORMING INSPECTIONS.
- 13) INSTALLATION INSPECTIONS SHALL INCLUDE, AS A MINIMUM THE FOLLOWING ATTRIBUTES, AS APPLICABLE TO THE EQUIPMENT BEING INSPECTED:
 - A) ANCHOR BOLT PLACEMENT
 - B) ANCHOR BOLT TORQUE
 - C) LOCATION
 - D) ELEVATION
 - E) ORIENTATION
- 14) INSPECTIONS SHALL INCLUDE VERIFICATION FOR POTENTIALLY SUSPECT / COUNTERFEIT ITEMS PER MCP-9-10.
- 15) ALL ATTRIBUTES IN THIS PLAN, EXCEPT THOSE THAT REQUIRE A SPECIFIC QUALIFICATION, (I.E. WELDING, NDE, HYDROSTATIC, PNEUMATIC, ETC.) MAY BE PERFORMED BY QUALIFIED PERSONNEL OTHER THAN A "GENERAL INSPECTOR".
- 16) WHEN CONFLICTS ARISE THAT PRECLUDE THE INSPECTOR FROM PERFORMING A VERIFICATION ACTIVITY, THE INSPECTOR IS ALLOWED TO DOCUMENT COMPLETION OF INSPECTION STEPS BASED ON OBJECTIVE EVIDENCE FROM THE COGIZANT ST3 OR Q6 THAT THOSE STEPS HAVE BEEN COMPLETED AS DESCRIBED IN THE INSPECTION PLAN. ATTACH COPIES OF THE OBJECTIVE EVIDENCE TO THIS PLAN.

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